Reference Version

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	NOTE CAUTION WARNING										
	THIS ATS COVERS ALL THE INTEGRATION STEPS NEEDED FOR THE TTCB-FM SECONDARY INSTALLATION										
	The purpose of this ATS is to specify the TTCB installation of the TTCS boxes, that will be performed at AIDC Taiwan.										
The Project Engineer: Johannes van Es (TTCS) has the option to reord on site as required.						er steps					
			HANDI	LING A	ND	HARDWA	RE INSTAL	LATION			
		E	ach operation o				l be done wea ing instructio		d in		
			All the integra	tion act	iviti	ies shall be	done by qual	lified personne	el.		
		The I	FTCS Project	Enginee	r ha	s the authout of ord		the steps in th	is ATS		
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The purpose of the present document is to provide information and guidelines for the installation of the TTCB FM2 components on its support and the installation into the TTCB. The integration sequence are described in	The purpose of the present document is to provide information and guidelines for the installation of the TTCB FM2 components on its support and the installation into the TTCB. The integration sequence are described in						
			The purpose of the present document is to provide the installation of the TTCB FM2 components on into the TTCB. The integration sequence are described by the installation of the TTCB. The integration sequence are described by the installation of the TTCB. The integration sequence are described by the installation of the TTCB.	its support and the bed in	e installation		

### 5. Page ATS 090127-1-R0 AMS-02 TASK SHEET (ATS) 4. ATS NO. CONTINUATION PAGE 6. MOD NO 20, OPER SEQ. NO. VERIFICATION 21. OPERATIONS (Print, Type, or Write Legibly) 22. TECH 23. QA/DV APPLICABLE DOCUMENTS The following documents in the latest applicable issue form a part of this plan to the extent specified herein: AD Document ID Issue/Rev Title TTCS Box Welding AMSTR-NLR-PR-021 6.4 Procedure 2 ET5998-08-01 ASSY TTCB P FM 3 ET6029-05-031 F/ ASSY HX FM S ET6029-05-019 Н/ HX FM P CLIP AND SUPPORT 5 ET5998-08-10 D/ TTCB FM Assembly base ଚ AMSTR-NLR-PR-062 1.0 TTCB-S Box welding procedure STANDARD AND SPECIAL TOOLS For the hardware installation a standard tool shall be used. Where the use of standard tooling is not possible, special tool may be employed. Each special tool has to be identified with its Drawing Number marked, in indelible way, on the same tool All the tools have to be clean and free from dust and grease. For the present installation only standard tools are needed **RUNNING TORQUE MEASUREMENT** In the present integration activity we have to consider several types of locking as coupling by inserts and few by locking features on the bolts. This value is an output from Specification will as 917 see below table.

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#### 116 5. Page ATS 090127-1-R0 4, ATS NO. AMS-02 TASK SHEET (ATS) CONTINUATION PAGE 6 MOD NO. VERIFICATION 21. OPERATIONS 20. OPER SEQ. NO. 22. TECH 23. QA/DV MTI-1-45914A TABLE I. Internal thread self-locking torque (inch pounds). Minima Maximam Insert Internal Breakoway **Locking** Torque Torque Fire or Coarse .086 2.5 .112 1.8 10 .138 1.5 15 .164 190 30 250 60 6.8 9.5 14.0 100 4375 500 150 24.0 200 5625 32.0 .625 .750 ann 70.0 600 90.0 1,000 Table 1: Running torque values according to MIL-I-45914A Since it is a continuous torque it is necessary to measure it with an analogical torque wrench, obtaining the maximum torque applied during this operation. The Locking Torque value has to be written in the relative box in the Integration Procedure Table and added to the Seating Torque required in the structural analysis, (and reported in the engineering drawings) FINAL INSTALLATION TORQUE MEASUREMENT Final Torque to be applied to each screw is the result of the sum of the Locking Torque (measured) and the Seating Torque prescribed from the structural analysis (and reported also on the engineering drawing). The Seating torques to be applied for each screws are listed in this ATS The entire torque shall be applied using calibrated torque wrench TORQUE (T)= SEATING TORQUE (ST) +LOCKING TORQUE (RT) SEATING TORQUE (from structural analysis) LOCKING (= RUNNING) TORQUE (measured)

### 5. Page 116 ATS 090127-1-R0 AMS-02 TASK SHEET (ATS) 4, ATS NO. CONTINUATION PAGE 6. MOD NO. VERIFICATION 21. OPERATIONS (Print, Type, or Write Legibly) 22. TECH 23. QA/DV **LUBRICATION** All these fasteners shall be installed in LUBRICATED condition (according to the structural analysis) The below Step by Step procedure, have to be followed for all the fittings to be used for the parts installation. STEP **OPERATION** Clean screws and washers in an Isopropyl Alcohol bath 2 Let the screws and washers dry on a clean towel Perform a screws and washers visual Inspection Install the HX-support assembly with the washers to the TTCB-P base plate Add Koropron primer if indicated 5 Measure the Locking Torque and register the value in the Integration Procedure Tables The Integration Procedure Tables are part of the present document Torque the bolts to the final torque values 1.1 WARNING: for TTCB installation reference drawings are: ET5998-08-DR-001-E-KW-ASSEMBLY TTCB FM.pdf ET5998-08-DR-002-D-KW-ASSY COVER pdf ET5998-08-DR-003-C-KW-ASSY PLATES.pdf ET5998-08-DR-004-E-KW-ASSY TUBING.pdf ET5998-08-DR-005-E-KW-ASSY APS.pdf ET5998-08-DR-006-E-KW-ASSY DPS.pdf ET5998-08-DR-010-D-KW-ASSY BASE.pdf ET5998-08-DR-011-C-KW-SIDE PLATE.pdf ET5998-08-DR-012-A-KW-PP BOX.pdf ET5998-08-DR-013-C-KW-CONNECTOR PLATE.pdf ET5998-08-DR-014-F-KW-APS + DSP SUPPORT.pdf ET5998-08-DR-015-0-KW-THERMAL WASHERS.pdf ET5998-08-DR-016-A-KW-BRACKET PP FRONT.pdf ET5998-08-DR-017-A-KW-BRACKET PP BACK.pdf AMS Assembly Task Sheet (ATS) Continuation Rev 9/25/05 JH

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Open this	ATS									
2. INSTA	ALLATION OF PUMP CONTROLLER (	ONTO THE TTCB BAS	E PLATE							
2.1	Prepare the TTCS PUMP CONTROLLER inspection of the parts to be installed; clea Isopropyl Alcohol and let the parts to be in	n the parts to be installe	d with							
2.2	Prepare screws and washer to be used for and washer visual inspection; clean screw bath and let screws and washers dry on a con-	s and washers in an Isop		A A A A A A A A A A A A A A A A A A A						
2.3	Perform a visual inspection of the base plate; check the cleanliness of all the inserts. If necessary clean them with Isopropyl Alcohol									
2.4	Weight all the hardware to be installed,	including fasteners. Re-	cord the weight		variation of the state of the s					
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	ITEM	WEIGHT		-						
	Botts (NASIZIN3-10) × 6	19.09 g		J 4 1	Jason					
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2.6 WARNING: TTCB installation reference drawings are as indicated at the start of this ATS.	23. Q/VOV
2.6.1 Check the bill of material in the assembly drawing.	
2.6.2 Component apply a thin layer of Koropron primer in between washers and base plate and or component.	
Koropron primer - PN Lot# 370055 Exp. Date #84/09 Jv E  2.6.3 Install the indicated component on the TTCB base plate as shown in the figure	Jacon
2.6.3 Install the indicated component on the TTCB base plate as shown in the figure below.	
prior to instellation prefure.  11:22  Teb26:2009	
(Screw) NAS1351N3-10 X 6	
Figure 4: Installation of PUMP CONTROLLER to base plate  AMS Assembly Task Sheet (ATS) Continuation Rev 9/25/06 JH	

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2.6.4	Apply a thin layer of Green prior the installation (as rep				ach bolt				
	Braycote Grease - PN  601 FF 25012 -	Lot#	Exp. Dat	te M 0 6 02	0 P-	JUE	Jason		
2.7	Install the fasteners as per fig hand)	•							
	Bolt/washer/nut and number	NAS numbe	er LO	OT					
:	LOT#_								
		JCH							
	Bolds	NAS 13+1N3-10/LOT# 46/17							
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2.8	Torque the fasteners installed torque values are shown in be	elow table.		torque value.	Seating				
	Dash Number	Torque	(in*lbf)	_					
	33 4537 1 (417.5 4)	Max	Min						
	Screw NAS1351N3-10	42.237	35.901						
2.9	Check this value with the table								
	Locking torque shall be in between 2–18 inch*lbf (size 0.190).								
2.10	Check this value with Table 1 Final torque shall be the seatin 5% precision on torque.			TORQUE.					

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	Torque Wrench- Locking Torque (le PN XQAA 03 09 M#  Torque Wrench- Final Torque PN XQAA 03 09 Bolt indication (see figure above)	Cal Ca l Cal	PC_6   22/200 2008, 15/200 15/200 200,2	JUE JUE JUE JUE	Jel-1 Japon Japon Japon	2000	

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3. INSTA	ALLATION OF APS ONTO THE TTCB E Prepare the APS for installation. Perform installed; clean the parts to be installed w	a visual ins	spection of the pa			
3.2	be installed dry on the clean towel  Prepare screws and washer to be used for and washer visual inspection; clean screw bath and let screws and washers dry on a	vs and wash	ers in an Isoprop			
3.3	Perform a visual inspection of the base inserts. If necessary clean them with Isop			ess of all the	<b>a</b>	
3.4	Weight all the hardware to be installed,	including	fasteners. Recor	d the weigh	t	
	ITEM  Bolts (NAS 13 t2Nob-8) x 4  (NAS 13 t2Nob-8) x 4  Washer.  NAS 1149 EN 832 R x 4	WEIGHT	10,84	g. g.	JeH	Japon
	Themal Washer.  14.1 x 4  14.2 x 4.		3.78 5.60	g g .		
3.5	SCALE PN AJ_ (12007) 320/07-17 WARNING: TTCB installation referen		al Dates are as indicated		JH	Jacon
ANG Assessed	of this ATS.  Verify before use the availability of the	approved c	drawing revision			

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3.6.1	Check the bill of material in the assembly drawing	ÿ.			
3.6,2	between washers and base plate and or component	t.		711	Tuom
3.6,3	Koropron primer - PN Lot# 37 06 と Lt-7の/4/0 - プロ Lot# 37 06 と Lt-7の/4 と L	Exp. Date	in the figure	101	
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	(Screw) FAS1352N36-3	िरि	T 10	ermal Wa x 4.4 x 3	sher -15.1
	X 4			x 4.4 x 5	X 4
3.6.4	Figure 4: Installation of APS to base plate  Apply a thin layer of Grease Bridge Property of the installation (as reported on the assembly of Braycote Grease - PN Lot# Lot# Lot# E			IUH,	Jaoon
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AMS-02 TASK SHEET (ATS) CONTINUATION PAGE  22 OPER SECOND  3.70  Install the fasteners as per figure 4 and record fasteners lot number (write by hand) Bolt/washer/nut and number  NAS number  LOT  LOT#  LO						5 Page 14		116
3.7 Install the fasteners as per figure 4 and record fasteners lot number (write by hand) Bolt/washer/nut and number  NAS number  LOT  LOT#  LOT			•		4. ATS NO.	ATS	090127-1	-R0
3.7 Install the fasteners as per figure 4 and record fasteners lot number (write by hand) Bolt/washer/nut and number  NAS number  LOT#  LO		CONTINUATION PA	AGE		6. MOD NO.			
Install the fasteners as per figure 4 and record fasteners lot number (write by hand)  Bolt/washer/nut and number NAS number LOT  LOT#  LOT#  LOT#  LOT#  Bolt NSSETWE-14 LOT#						VERIF	CATION	
hand) Bolt/washer/nut and number NAS number LOT LOT# LOT# Bolt MSINTW6-8 LOT# SUST SUST SUST SUST SUST SUST SUST SU							22. TECH	23. QA/DV
LOT#   SUBSTITUTE   LOT#   SUBSTITUTE   SU	3.7	hand)				write by		
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Bolt MS/RJ2/MS-14 LOT# ST4 ST ST NASIBER NASIBERNOS-18 13.861 11.782  Screw NASIBS2NOS-14 24.944 21.203  Check this value with the table at the end of this ATS.  Locking torque shall be in 1.0-10 inch*lbf (size 0.138) for NASI352NOS-14  Check this value with Table 1 at the start of this ATS.  Check this value with 2 the seating torque ABOVE LOCKING TORQUE. Start Torque shall be the seating torque ABOVE LOCKING TORQUE. Start Torque shall be the seating torque ABOVE LOCKING TORQUE. Start Torque shall be the seating torque ABOVE LOCKING TORQUE. Start Torque shall be the seating torque ABOVE LOCKING TORQUE.				LO	T#		-	Tanna
Thermal wosles  Thermal wosles  I. I. LOT#  Screw  NAS1352N06-8  Screw  NAS1352N08-14  13.861  11.782  Screw  NAS1352N08-14  24.944  21.203  Check this value with the table at the end of this ATS.  Locking torque shall be in 1.0-10 inch*lbf (size 0.138) for NAS1352N06-8  Locking torque shall be in 1.5-15 inch*lbf (size 0.164) for NAS1352N08-14  Check this value with Table 1 at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.  S% precision on torque.		Boll	NAS1342NOG.	-8	- X43	87	1007	Japan
Thermal wosles  Thermal wosles  I. I. LOT#  Screw  NAS1352N06-8  Screw  NAS1352N08-14  13.861  11.782  Screw  NAS1352N08-14  24.944  21.203  Check this value with the table at the end of this ATS.  Locking torque shall be in 1.0-10 inch*lbf (size 0.138) for NAS1352N06-8  Locking torque shall be in 1.5-15 inch*lbf (size 0.164) for NAS1352N08-14  Check this value with Table 1 at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.  S% precision on torque.		Bolt	NAS BIZNOS-	-/4 <u>L</u> 0	T# 1348	5413		
Torque the fasteners installed in the former step to the final torque value. Seating torque values are shown in below table.    Dash Number			NAS/149EN	832R LO	T# 8714-1	0-9-03		
LOT#  Dash Number  Torque (in*lbf)  Max Min  Screw  NAS1352N06-8  Screw  NAS1352N08-14  24.944  21.203  3.9 Check this value with the table at the end of this ATS.  Locking torque shall be in 1.0 -10 inch*lbf (size 0.138) for NAS1352N06-8  Locking torque shall be in 1.5 -15 inch*lbf (size 0.164) for NAS1352N08-14  3.10 Check this value with Table I at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.  5% precision on torque.		Thermal Washer	过.1	LO	T#	n v		
Torque the fasteners installed in the former step to the final torque value. Seating torque values are shown in below table.    Dash Number		Thermal Washer	15. t.	LO	T#			Action in the case of the case
Torque the fasteners installed in the former step to the final torque value. Seating torque values are shown in below table.    Dash Number			w	LO	T#			A 14 A 14
Torque the fasteners installed in the former step to the final torque value. Seating torque values are shown in below table.    Dash Number				LO	Т#			
Dash Number  Max  Min  Screw  NAS1352N06-8  Screw  NAS1352N08-14  24.944  21.203  3.9 Check this value with the table at the end of this ATS.  Locking torque shall be in 1.0 -10 inch*lbf (size 0.138) for NAS1352N06-8  Locking torque shall be in 1.5 -15 inch*lbf (size 0.164) for NAS1352N08-14  3.10 Check this value with Table I at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.  5% precision on torque.	3.8		below table.		final torque v	alue. Seating		
Screw NAS1352N06-8  Screw NAS1352N08-14  24.944  21.203  Check this value with the table at the end of this ATS.  Locking torque shall be in 1.0 -10 inch*lbf (size 0.138) for NAS1352N06-8 Locking torque shall be in 1.5 -15 inch*lbf (size 0.164) for NAS1352N08-14  Check this value with Table 1 at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.  5% precision on torque.		Dash Number	Torque (in*lbt)					
Screw NAS1352N06-8  Screw NAS1352N08-14  24.944  21.203  Check this value with the table at the end of this ATS.  Locking torque shall be in 1.0 -10 inch*lbf (size 0.138) for NAS1352N06-8 Locking torque shall be in 1.5 -15 inch*lbf (size 0.164) for NAS1352N08-14  Check this value with Table 1 at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.  5% precision on torque.			Max	Min				
NAS1352N08-14  24.944  21.203  Check this value with the table at the end of this ATS.  Locking torque shall be in 1.0 -10 inch*lbf (size 0.138) for NAS1352N06-8  Locking torque shall be in 1.5 -15 inch*lbf (size 0.164) for NAS1352N08-14  Check this value with Table 1 at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.  5% precision on torque.			13.861	11.78	2			
Locking torque shall be in 1.0 -10 inch*lbf (size 0.138) for NAS1352N06-8 Locking torque shall be in 1.5 -15 inch*lbf (size 0.164) for NAS1352N08-14  Check this value with Table 1 at the start of this ATS. Final torque shall be the seating torque ABOVE LOCKING TORQUE.  5% precision on torque.			24.944	21.20	3			
Locking torque shall be in 1.5 -15 inch*lbf (size 0.164) for NAS1352N08-14  Check this value with Table 1 at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.  5% precision on torque.	3.9	Check this value with the ta	ble at the end o	of this ATS.				
Final torque shall be the seating torque ABOVE LOCKING TORQUE.  5% precision on torque.							der	
AMS Assembly Tesk Sheet (ATS) Continuation Rev 9/25/05 JH	3.10	Final torque shall be the sea				JE.		
MINICIPATED BY A CONTRACT OF THE PROPERTY OF T		Tack Sheet (ATS) Continuation Day 9/25/05 (D						

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SEQ. NO.	(Pri	int, Type, or Write Legibly)			22. TECH	23. QAVDV
	APS_C_4  APS_C_3  APS_C_3  Torque Wrench- Locking Torque (1) PN XOADOSOG M#  Torque Wrench- Final Torque PN XORCOTAS M#  Bolt indication (see figure above)  APS_C_3  APS_C_3  APS_BP_1  APS_BP_1  APS_BP_3  APS_BP_4	APS_BP  APS_BP  Locking is the sam  Cal  Cal	Due Date $\frac{\frac{1}{2}}{\frac{1}{2}}$ The as running torque of $\frac{1}{2}$ Due Date $\frac{\frac{1}{2}}{\frac{1}{2}}$ The Final True of $\frac{1}{2}$ The	APS   APS	BP3 BP4  JCH  JCH  JCH  JCH  JCH  JCH  JCH  JC	
	End of online operation APS to ba	se plate				

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	AMS-02 TASK SHEET (ATS)	4, ATS NO	ATS	090127-1	-R0
	CONTINUATION PAGE	6. MOD NO.			
20. OPER SEQ. NO.	21, OPERATIONS (Print, Type, or Write Legibly)	)		VERIFI 22. TECH	CATION 23. QA/DV
4. INSTA	ALLATION OF <b>DPS</b> ONTO THE TTCB BASE P	LATE			
4.1	Prepare the DPS for installation. Perform a visua installed; clean the parts to be installed with Isop be installed dry on the clean towel	l inspection of the p ropyl Alcohol and le	arts to be et the parts to		
4.2	Prepare screws and washer to be used for the par and washer visual inspection; clean screws and w bath and let screws and washers dry on a clean to	vashers in an Isoprop			
4.3	Perform a visual inspection of the base plate; inserts. If necessary clean them with Isopropyl A		ess of all the		
4.4	Weight all the hardware to be installed, includ-	ing fasteners. Recor	rd the weight		
	ITEM WEIG	НТ			
	80/14			JCH	Inson
	NAS/352N06-8 XY	4.84	J		Lason
	NAS 13.72NOB -14 X4	10. M	9		
	Washor. NAS1149ZN/83ZR XX	1.49	1	overfor the frame and the following	
	Thermal Washer			Andreas de la contraction de l	
	15.1 ×4	3.28 g.		Participate of the state of the	
	15.2 x4	160			
1				**************************************	
STOCKET AND ACCESSED.	SCALE AT LOOUT	ĸ),,	1201		
4.5	PN	Cal Date Od / 10	1 26001	JUH	Jacon
4.6	WARNING: TTCB installation reference draw of this ATS.  Verify before use the availability of the approve	_			
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	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS	090127-1	-R0	
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00 0050	21. OPERATIONS			VERIF	CATION	
20. OPER SEQ. NO.	(Print, Type, or Write Legibly)			22. TECH	23. QAVOV	
4.6.1	Check the bill of material in the assembly drawing			:	ARABAMA WORKSONER CO.O.	
4.6.2	between washers and base plate and or component	t.	. / _	JCH.	Juson	
4.6.3	Koropron primer - PN Lot#3706は ゴビーフットタリローファント Install the indicated component on the TTCB base below.	e plate as shown	in the figure			
The Proposition of the Propositi			г			
				(Screw) N	A\$1352N06	
		(A)				X4
	paramanananan sa	(P)		-	1847	
	(Somw) MAS 1 4021403 14  (Washer) NAS 1149EN832R  Thermal Washer-15.1 10 x 4.4 x 3  Thermal Washer-15.2 10 x 4.4 x 5	14.2 Isome	Atric vion		15.17	
4.6.4	Apply a thin layer of the Braycote Grease - PN Lot# /3±999 E	, to the thread drawings). Exp. DateO	s of each bolt	JeH	Jacon	
AMS Assembly	fask Sheet (ATS) Continuation Rev 9/25/06 JH			-		

	AMS-02 TASK SHEE	ET (ATS)		4 ATS NO	AT	S 090127-	1-R0
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PER		21. OPERAT			1		CATION
NO.	Tootall the Coster are so you f	(Print, Type, or Wr		lat number (	wita hu	22 TECH	23. QA/DV
	Install the fasteners as per f hand) Bolt/washer/nut and number			LOT	write by		
	P I I	·100 121-111	LOT	`#	287	TUH.	Jason
	Bolt ,	NAS BEZNOS	LOT	# 014	30 T	West	
	Washer	NAS 1352NOS NAS 1312NOS NAS 114961	VB>R LOT	# 87/4-16	-9-03		
	Thermal Washer Thermal Washer	15.	LOT	# Made	by AIN	c (Ti	tatiu
	evenual Masuer		LOT		by ALD		
			LOT	#		-	
	Torque the fasteners installe torque values are shown in	ed in the former below table.	LOT	#		-	
	Torque the fasteners installe	ed in the former below table.	LOT	#		-	
	Torque the fasteners installe torque values are shown in	ed in the former below table. Torque	LOT  step to the f  (in*lbf)	#		-	
	Torque the fasteners installe torque values are shown in Dash Number	ed in the former below table. Torque Max	LOT LOT step to the f (in*lbf) Min	# inal torque va		-	
	Torque the fasteners installe torque values are shown in Dash Number  Screw  NAS1352N06-8  Screw	ed in the former below table.  Torque  Max  13.861  24.944  ble at the end of the control of the	LOT LOT step to the final step	for NAS135	alue. Seatin	-	

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	AMS-02 TASK SHEET (ATS	1	4, ATS NO.	ATS	090127-1	-R0
	CONTINUATION PAGE	,		and the second character of the second control of the second contr		
	·		6, MOD NO.			
20, OPER SEQ. NO.		21. OPERATIONS Type, or Write Legibly)			22. TECH	CATION 23, QA/DV
4.11	DPS_C_1  DPS_C_2  DPS_C_2  DPS_C_3  Isometric view  Torque Wrench- Locking Torque (locking Torque)  Torque Wrench- Final Torque	DPS  DPS  DPS  Ca  Ca  Ca  Ca  Ca  Ca  Locking Torq  10	al Due Date    Color	DPS.  [ue) 2/20/ 15/207  Torque  7 7 7 8 8 8 8	BP_3 BP_4  BP_4  JCH JCH JCH TCH TCH TCH TCH TCH TCH TCH TCH TCH T	Japon Japon Japon Japon Japon Japon Japon Japon Japon
AMS Assembly	Task Sheet (ATS) Continuation Rev 9/25/05 JH					

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	AMS-02 TASK SHEET (ATS)		4 ATS NO	ATS	090127-	1-R0
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20. OPER		RATIONS		<u> </u>		ICATION
SEQ. NO.	INSTALLATION OF PIPE BRACKET	Y Write Legibly)	BASE PLATE		22, TECH	23. QAVDV
5,1	Prepare the PIPE BRACKET for installa parts to be installed; clean the parts to be the parts to be installed dry on the clean	tion. Perfor installed w	m a visual inspec	tion of the cohol and let		
5.2	Prepare screws and washer to be used for and washer visual inspection; clean screw bath and let screws and washers dry on a	ws and wash	iers in an Isoprop			
5,3	Perform a visual inspection of the bas inserts. If necessary clean them with Ison			ess of all the		
5.4	Weight all the hardware to be installed	l, including	fasteners. Recor	d the weight		
	ITEM	WEIGHT				
	Bolts					\
	NAS13t2NO6-6	(	1,20 8.		JCH	Jason
	NAS13t2NOB-8		7. £4 £.			
5.5	SCALE PN M#		Cal Date OF/14	12008	JCH	Jason
3.3	32010757		ou Date		age of the second secon	
5.6	WARNING: TTCB installation reference of this ATS.  Verify before use the availability of the			at the start		
5.6.1	Check the bill of material in the assem	bly drawing	Ţ,			
AMS Assembly	Task Sheet (ATS) Continuation Rev 9/25/05 JH					

			5. Page 21	of	116
	AMS-02 TASK SHEET (ATS)	4. ATS NO.		090127-1	
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20. OPER	21. OPERATIONS				CATION
5.6.2	(Print, Type, or Write Legibly)  Only The Late of the	of Karanran n	rimer in	22. TECH	23. QA/DV
5.0.2	hetween washers and base plate and or component	•			
	Koropron primer - PN Lot#370 LLS	Exp. Date	4/0 9	Jel	Jason
5.6.3	Koropron primer - PN Lot# 370 LS Alt 700 1910-704 Install the indicated component on the TTCB base below.	plate as showr	in the figure		
		3			
				ÿ	
	(Screw)NAS1352N08-8	1888	(Screw )NAS1	ļ , , , , , , , , , , , , , , , , , , ,	
	Figure 4: Installation of PIPE BRACKETS to base	: plate			
5.6.4	Apply a thin layer of Chease Brancote 601 DF (G) prior the installation (as reported on the assembly a Braycote Grease - PN Lot# 13 £999 E 601 & T > 2492-AMSB	, to the threads		JUN	Jacon
	fask Sheet (ATS) Continuation Rev 9/25/06 ЈН				

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	CONTINUATION	-AGC		6. MOD NO.		7	
20, OPER SEQ. NO.			RATIONS r Write Legibly)			VERIF	23. QA/DV
5.7	Install the fasteners as per hand) Bolt/washer/nut and numb	_			write by		
			L	OT#			
	AND THE PROPERTY OF THE PROPER			OT#		de de la desarra de la desarra de la desarra de la dela dela dela dela dela dela de	
	Bott	NAS/357	N06-6 L	от# от# <i>849</i> 0 от# <i>8</i> 40.	8	Jun	Jacon
		NASBERA	14-8 L	OT#	}-o		
				OT#			
				OT#			
			L	OT#			
				OT#			
5.8	Torque the fasteners instal torque values are shown in	below table.	ner step to th	ne final torque va	alue. Seating		
	Dash Number	Max	Min				
TO TO THE PROPERTY OF THE PROP	Screw NAS1352N08-8	24.944	21.203				
	Screw NAS1352N06-6	13.861	11.782				
5.9	Check this value with the t	able at the end	l of this AT	S.			
	Locking torque shall be in Locking torque shall be in	1.5 – 15 inch* 1.0 -10 inch*l	blbf (size 0.1)	164) for NAS13 38) for NAS135	52N08-8 52N06-6		
5.10	Check this value with Tab. Final torque shall be the se 5% precision on torque.				JE.		
AMS Assembly	Task Sheet (ATS) Continuation Rev 9/25/06 JH			The state of the s		<u> </u>	<u> </u>

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SEQ. NO.	(Print, Type, or Write Legibly)			22. TECH	23. GA/DV
		pr	BP4		
		PB_BP_2			
			Ů(€) °-pc	_3	1
				<u> </u>	
	PB_BP_3		P	C_4	
:	PB_BP_1				
	PC_1				
	ar (artir PC_2				
			an an and an		
		1			
		(sciew)sv	S1352N06-6		
	(Screw)NAS1352ND8-8		[X 4		
	N 4	The second state of the second	mercum total philosophic philosophic and many many and a part of the philosophic philosoph		
	Base and a second secon				
	Torque Wrench- Locking Torque (locking is the san	ne as running tor	que)		
	PN X QWC0/12 M# Ca	I Due Date $\frac{\partial f}{\partial x}$ I Due Date $\frac{\partial f}{\partial x}$	1/4/2006	Tus	Ta again
	Torque Wrench- Final Torque		/	-41	
у гууналач алаан	PN XORCOOTS M# Ca	I Dua Data	1 H/2008		
	Bolt indication (see figure above) Locking Torques (1979)		d Torque		
	PB_BP_1 6	, 41.6.1.6.1.4.4.4.4.4.4.4.4.4.4.4.4.4.4.4	30	1341	Jacon
	PB_BP_3		0	JUH	Jason
	pB_BP-2 6		° 0	JUY	Juegor
	PB_BP_4 6	3	7	JCH	Juan
	'				
		,	and the second s		
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20. OPER SEQ. NO.	(Print	21, OPERATIONS I, Type, or Write Legibly)			VERII 22. TECH	EICATION 23. QA/D
	Bolt indication (see figure above)	Locking Torqu	ne Fin	al Torque		
	pc_l	<i>-</i>	 /3+	d=18	JEH	Jacos
A CONTRACTOR OF THE CONTRACTOR	pc_ z	7		27	Jay Jay	Jazon
	PC_3	<u></u>	(	8	JCH	Jaso
	PC-4			20	Jay.	Jason
5.11	End of online operation PIPE BR	ACKET to base	plate			
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					Address of the second	
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	ik Sheet (ATS) Continuation Rev 9725/06 JH					

AMS-02 TASK SHEET (ATS) CONTINUATION PAGE  20. OPER SEQ NO.  21. OPERATIONS (Print, Type, or Wille Legibly)  6. INSTALLATION OF PIPE BRACKET TO TTCB COVER  6.1 Prepare the PIPE BRACKET for installation. Perform a visual inspection of the parts to be installed; clean the parts to be installed with Isopropyl Alcohol and let the parts to be installed dry on the clean towel  6.2 Prepare screws and washer to be used for the part installation. Perform a screws and washer visual inspection; clean screws and washers in an Isopropyl Alcohol bath and let screws and washers dry on a clean towel  6.3 Perform a visual inspection of the COVER; check the cleanliness of all the RIVNUTS. If necessary clean them with Isopropyl Alcohol  6.4 Weight all the hardware to be installed, including fasteners. Record the weight  ITEM WEIGHT  Jay				5. Page 25		116
20.0 PER SEQ. NO. 21 OPERATIONS (PRINT, Type, or White Legisty)  6. INSTALLATION OF PIPE BRACKET TO TTCB COVER  6.1 Prepare the PIPE BRACKET for installation. Perform a visual inspection of the parts to be installed; clean the parts to be installed with Isopropyl Alcohol and let the parts to be installed dry on the clean towel  6.2 Prepare screws and washer to be used for the part installation. Perform a screws and washer visual inspection; clean screws and washers in an Isopropyl Alcohol bath and let screws and washers dry on a clean towel  6.3 Perform a visual inspection of the COVER; check the cleanliness of all the RIVNUTS. If necessary clean them with Isopropyl Alcohol  6.4 Weight all the hardware to be installed, including fasteners. Record the weight		AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS	90127-1	-R0
6. INSTALLATION OF PIPE BRACKET TO TTCB COVER  6.1 Prepare the PIPE BRACKET for installation. Perform a visual inspection of the parts to be installed; clean the parts to be installed with Isopropyl Alcohol and let the parts to be installed dry on the clean towel  6.2 Prepare screws and washer to be used for the part installation. Perform a screws and washer visual inspection; clean screws and washers in an Isopropyl Alcohol bath and let screws and washers dry on a clean towel  6.3 Perform a visual inspection of the COVER; check the cleanliness of all the RIVNUTS. If necessary clean them with Isopropyl Alcohol  6.4 Weight all the hardware to be installed, including fasteners. Record the weight		CONTINUATION PAGE	6. MOD NO.			
6. INST ALLATION OF PIPE BRACKET TO TTCB COVER  6.1 Prepare the PIPE BRACKET for installation. Perform a visual inspection of the parts to be installed; clean the parts to be installed with Isopropyl Alcohol and let the parts to be installed dry on the clean towel  6.2 Prepare screws and washer to be used for the part installation. Perform a screws and washer visual inspection; clean screws and washers in an Isopropyl Alcohol bath and let screws and washers dry on a clean towel  6.3 Perform a visual inspection of the COVER; check the cleanliness of all the RIVNUTS. If necessary clean them with Isopropyl Alcohol  6.4 Weight all the hardware to be installed, including fasteners. Record the weight	20 OPER	21 OPERATIO	ONS		VERIF	ICATION
Prepare the PIPE BRACKET for installation. Perform a visual inspection of the parts to be installed; clean the parts to be installed with Isopropyl Alcohol and let the parts to be installed dry on the clean towel  Prepare screws and washer to be used for the part installation. Perform a screws and washer visual inspection; clean screws and washers in an Isopropyl Alcohol bath and let screws and washers dry on a clean towel  Perform a visual inspection of the COVER; check the cleanliness of all the RIVNUTS. If necessary clean them with Isopropyl Alcohol  Weight all the hardware to be installed, including fasteners. Record the weight  WEIGHT  WEIGHT					22. TECH	23. QAVDV
ITEM WEIGHT	6.2	Prepare the PIPE BRACKET for installation parts to be installed; clean the parts to be installed dry on the clean tow Prepare screws and washer to be used for the and washer visual inspection; clean screws a bath and let screws and washers dry on a clean town a visual inspection of the COVI RIVNUTS. If necessary clean them with Ison	n. Perform a visual inspect stalled with Isopropyl Alco vel ne part installation. Perform and washers in an Isopropy ean towel ER; check the cleanlines opropyl Alcohol	ohol and let a screws yl Alcohol s of all the		
	6,4	BOLL W	WEIGHT		JoH	Japon
SCALE PN AJ - 42007 M# Cal Date 08/14/2008 JCH J 320/0757.	6.5	SCALE PN AJ - 42007 M#	Cal Date 08/14	800<	Тен	Jazon
6.6 WARNING: TTCB installation reference drawings are as indicated at the start of this ATS.  Verify before use the availability of the approved drawing revision  AMS Assembly Task Sheet (ATS) Continuation Rev 9/25/05 JH	PORTONIA	of this ATS.  Verify before use the availability of the ap	-	at the start		

# p26-p28 See Addendum I.

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O. OPER	21. OPERATIONS (Print, Type, or Write Legibl	y)	22. TECH	IFICATION 1 23. QA/D
6.6.1	Check the bill of material in the assembly dra	wing.		
6.6.2	Only when indicated in drawing apply a thin I between washers and base plate and or composition of the Koropron primer - PN Lot# Lot# Lot# Lot# Lot# Lot# Lot# Lot#	enent.  Exp. Date	109 JU1	Jues
6.6.3	Install the indicated component on the TTCB below.	base plate as snown in	the figure	
	NAS 13 5 2 No6L 812 N2  ISCREW! NAS1352N06.11  N2  Figure 4: Installation of PIPE BRACKETS to			
	rigure 4. Institution of the blockers to	TTCR COVER		

## P26-P28 See Addendum I

	AMS-02 TASK SH	FET (ATS)		4. ATS NO.	ATS	090127-1	-R0
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.7	Install the fasteners as pe hand) Bolt/washer/nut and num  Replaced by bolts at CF	NASSELF	Snumber  LO  LO  LO  LO  LO  LO  LO  LO  LO  L	LOT  OT#  OT#  OT#  OT#  OT#  OT#  OT#	94	Jay Jos	Japon
	NAS 1352 N See Add	dendur		OT#		Ju E 10/111	roog
8	Torque the fasteners instatorque values are shown	alled in the foin below tabl	Drmer step to the	OT# OT#			Roog
.8	Torque the fasteners inst	alled in the foin below tabl	crmer step to the e.	OT# OT#			boog
8	Torque the fasteners instatorque values are shown	alled in the foin below tabl	Drmer step to the	OT# OT#			boog

## P26-P28 See Addendum I.

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	oommen nou	6. MOD NO.			
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SEQ. NO.	(Print, Type, or Write Legibly)		-	22. TECH	23. QA/D
6.11	Torque Wrench- Locking Torque (locking is the samp Normal Property Mark Carlor	al Due Date Of / k	1H1200	JeH Jay	Japon

20. OPER SEQ. NO.	AMS-02 TASK SHEET (ATS)  CONTINUATION PAGE  21. OPERA (Print, Type, or V		ATS		1-R0
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7. INSTA				22. TECH	23. QA/DV
7.1	Prepare the ACCU BRACKET TO A parts to be installed; clean the parts to be installed dry on the clean to	ation. Perform a visual insp nstalled with Isopropyl Al	pection of the cohol and let		
7.2	Prepare screws and washers to be used for and washer visual inspection; clean screw bath and let screws and washers dry on a	s and washers in an Isopro	orm a screws pyl Alcohol		
	Perform a visual inspection of the COI THREADED HOLES. If necessary clean				
7.4	Weight all the hardware to be installed,	including fasteners. Reco	rd the weight		
	ITEM	WEIGHT			
	BoHs	10			***************************************
	NACIZINOP-UB14 x 7. Washer	19.32	3	JCH	Japon
	NACIIL9EN832R X7	2.52 g.			
	SCALE AJ-LADOT	25/14	12008	TcH	Tanım
7.5	SCALE AJ_62005 PNM#	Cal Date			
7.6	WARNING: TTCB installation reference of this ATS.  Verify before use the availability of the ask Sheet (ATS) Continuation Rev 9/25/08 JH				

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	AMS-02 TASK SHEET (ATS)	4 ATS NO.	ATS	090127-1	-KU
	CONTINUATION PAGE	6, MOD NO.		1	
20, OPER SEQ. NO.	21. OPERATIONS (Print, Typs, or Write Legibly)			VERIFIC 22 TECH	CATION 23. QA/DV
7.6.1	Check the bill of material in the assembly drawing				
7.6.2	between washers and base plate and or componen  Koropron primer - PN  Lot#  Install the indicated component on the TTCB base	Exp. Date	4/09	Jett.	Treon
7.6.4	Install the indicated component on the TTCB bas below.  (Screw) NASI351N08-LB14  (Washer) NASI149EN832R  Threaded collar  Figure 4: Installation of ACCUMULATOR BRACA Apply a thin layer of prior the installation (as reported on the assembly braycote Grease - PN Lottle   35999   ColTF-2007-ANSB	CKET TO ACCI	UCOLLAR Is of each bolt	JCH	Jaeon
AMS Assembly	Task Sheel (ATS) Continuation Rev 9/25/06 JH				

			1 470 20	5.Pege 31 ATS 09	00127-1-	R0
	AMS-02 TASK SHEET (	ATS)	4. ATS NO.			
	CONTINUATION PAGE	6, MOD NO.		VERIFIC	ATION	
		-	22. TECH	23. QA/DV		
O. OPER SEQ. NO.	-,,	(Print, Type, or Write Leg-	089)			
7.7	Install the fasteners as per figure hand) Bolt/washer/nut and number	e 4 and record	. as and			
	- Andrew Control of the Control of t					
			LOT#			
			LOT#		-	.~
	b) 1	1 AS 13+1 NO	LOT# g_lgi <sup>l</sup> LOT#	ma 40347	pay	Jacon
	Bdt_					
		11.0-11	LOT#from da	ina	Jal	Jason
	Washer	JAMINATENS	LOT#			
	Topology - MARKET / M		LOT#			
			 LOT#			
	pour selection and the selecti					
		and the state of t	LOT#	THE RESERVE OF THE PARTY OF THE		
7.8	Torque the fasteners installed torque values are shown in b	GIOW MOIO.		e value. Seating	g	
		Torque	(in*lb1)			
	Dash Number	Max	Min			
	Screw		22.824			
	NAS1351N08-LB14	26.863	22.834			
			C.I. LIDO			
7.9	Check this value with the ta					
	Locking torque shall be in Locking is on the bolt side.					
7.1	O Check this value with Table Final torque shall be the se 5% precision on torque.	e 1 at the start of ating torque Al	of this ATS. BOVE LOCKING TO	RQUE.		

	AMS-02 TASK SHEET (ATS)	4.1	ATS NO.	·····		
	CONTINUATION PAGE	6. !	MOD NO.			
	21. OPER (Print, Type, or	ATIONS Write Legibly)			VERIFICA 22. TECH	ATIO 23.
Application of the second	Accu-Col_4  Accu-Col_3  Accu-Col_2  Accu-Col_1  Torque Wrench- Locking Torque (locking PN XOAR 03 X)  M#	Accurage is the same as a Cal Due	Date 05/3	28/2009 -0	1	
		Cal Due				
	Bolt indication (see figure above) Lo	1-1	Final T	orque	JCM	_
	Acu-col-1	10		- <u> </u>	7011	_
		to 10		37	7	Ú
		\$ 10	33	35	JOH	,
ĺ	24	12	3	1	Jeff	J
	*	8	33	3	Jan	-
			3	<u> </u>	JUH	-
		70	35		Jan Jan	
		10	كد		1300	-
				ngagagaa 15,1 panananana		
	End of online operation ACCU BRA					ĺ

				5. Page 33	ot 11 090127-1-	6 R0
	AMS-02 TASK SHEET (ATS)		4. ATS NO.	A10	070127-1".	
	CONTINUATION PAGE		6, MOD NO.			
	21, OPERA'	TIONS		······································	VERIFIC 22. TECH	ATION 23. QA/DV
20. OPER SEQ. NO.	(Print, Type, or ₩	rite Legibly)			22. 16.01	
8. INSTA	LLATION OF PIPE CLAMP TO ACCU	BRACK	ETS			
8.1	Prepare the ACCU PIPE CLAMP for insta the parts to be installed; clean the parts to let the parts to be installed dry on the clean	allation. Pe be installe n towel	erform a visual in d with Isopropyl	THOUSE SEE		
8.2	Prepare screws and washers to be used for and washer visual inspection; clean screw bath and let screws and washers dry on a	s and was clean towe	ders m an isopro	p, 1 1 1 2 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3		
8.3	Perform a visual inspection of the ACCU the INSERTS. If necessary clean them wi	tu isobiot	ly i Alconor			
8.4	Weight all the hardware to be installed,	including	fasteners. Reco	ord the weigh	ıt	
	ITEM	WEIGH	r			
	Bolt					
A CONTRACTOR OF THE CONTRACTOR	NASISTINGL-10 XY. NASII49ZNZ32R X4.	<b>&gt;</b>	4.70 9		Jay	Jacon
	brackeds	3	o 68 g			
8.5	SCALE PN AJ-42007 320107±7		Cal Date	14/2008	JCH	Jaeon
8.6	WARNING: TTCB installation reference of this ATS.  Verify before use the availability of the stallation reference to the stallation reference	ence drawi	ngs are as indica	nted at the star	1	

			5. Page 34 of	116
	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS 0901	27-1-R0
	CONTINUATION PAGE	6. MOD NO.		
20. OPER SEQ. NO.	21. OPERATIONS (Pnnt, Type, or Write Legibly)		20.	VERIFICATION
8.6.1	Check the bill of material in the assembly drawi	ng.	22.	TECH 23. QAVDV
8.6.2	One rates indicated in the apply a thin lay between washers and base plate and or compone	er of Koropron prim	er in	
8.6.3	Koropron primer - PN Lot#  5/5 / Joe 1910 / Joe 1/2  Install the indicated component on the TTCB babelow.	Exp. Date 4/2 se plate as shown in	the figure	E JCH
Action and the second				
	(Washer) NAS1149EN532R (Unsert) MS21209F0625		g gal	
8.6.4	Apply a thin layer of Grease Employees prior the installation (as reported on the assembly Braycote Grease - PN 601 EF Lot# 135999 25012 AMS 13	, to the threads of drawings).	each bolt	<u>=</u> JcH.

AMS Assembly Task Sheet (ATS) Continuation Rev 9/25/08 JH

CONTINUATION PAGE  21. OPERATIONS SEQ. NO.  21. OPERATIONS (Print, Type, or Write Legisly)  8.7 Install the fasteners as per figure 4 and record fasteners lot number (write by hand) Bolt/washer/nut and number  NAS number  LOT#  LOT#  LOT#		AMS_02 TACK CHE	ET (ATC)		4. ATS NO.	5. Page 35 ATS	of 090127-	1-R0
VERIFICAL SECTION   VERI							······································	
Install the fasteners as per figure 4 and record fasteners lot number (write by hand)  Bolt/washer/nut and number  NAS number  LOT#				G. MOD NO.		Vernu	FICATION	
hand) Bolt/washer/nut and number NAS number LOT  LOT#							23. 0	
torque values are shown in below table.    Dash Number		hand) Bolt/washer/nut and number	NAS num  NAS num  NAS 11497	LOT# LOT# LOT# LOT# LOT# LOT# LOT# LOT#	10T 38920 Ф	Ask SYSU Ask SYSU		
Dash Number  Max  Min  Screw  NAS1351N06-10  15.662  13.312  Check this value with the table at the end of this ATS.  Locking torque shall be in 1-10 inch*lbf (size 0.138)  Check this value with Table 1 at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.				LOT#				
Screw NAS1351N06-10  Check this value with the table at the end of this ATS.  Locking torque shall be in 1-10 inch*lbf (size 0.138)  Check this value with Table 1 at the start of this ATS.  Final torque shall be the seating torque ABOVE LOCKING TORQUE.	}		ed in the forme below table.	r step to the fir				
Locking torque shall be in 1-10 inch*lbf (size 0.138)  Check this value with Table 1 at the start of this ATS. Final torque shall be the seating torque ABOVE LOCKING TORQUE.	•	torque values are shown in	ed in the forme below table.  Torque	r step to the fine (in*lbf)				
Locking torque shall be in 1-10 inch*lbf (size 0.138)  Check this value with Table 1 at the start of this ATS. Final torque shall be the seating torque ABOVE LOCKING TORQUE.	***************************************	Dash Number Screw	ed in the forme below table.  Torque  Max	r step to the fire (in*lbf)  Min				
10 Check this value with Table 1 at the start of this ATS. Final torque shall be the seating torque ABOVE LOCKING TORQUE.		Dash Number  Screw NAS1351N06-10	Torque Max 15.662	r step to the fire (in*lbf)  Min  13.312				
Final torque shall be the seating torque ABOVE LOCKING TORQUE.		Dash Number  Screw NAS1351N06-10  Check this value with the ta	Torque Max 15.662	r step to the fire (in*lbf)  Min  13.312  of this ATS.				
		Dash Number  Screw NAS1351N06-10  Check this value with the ta	Torque Max 15.662	r step to the fire (in*lbf)  Min  13.312  of this ATS.				

Torque Wrench- Locking Torque (locking is the same as running torque)  PN XQLAGGO M# Cal Due Date 66/32/2009  Torque Wrench- Final Torque  PN Same as Running torque  Bolt indication (see figure above) Locking Torque  Final Torque  Accu 1.2  Accu 1.3  Accu 1.7  Accu 1.2  Accu 1.2  Accu 1.3  Accu 1.5  Accu 1.2  Accu 1.3  Accu 1.5  Accu 1.2  Accu 1.3  Accu 1.5  Accu 1.2  Accu 1.3  Accu 1.3  Accu 1.5  Accu	or 116 90127-1-R0
Torque Wrench- Locking Torque (locking is the same as running torque)  PN XQL AGG M#  Cal Due Date 06/22/2002  Torque Wrench- Final Torque  PN Same as Running torque  Cal Due Date  Cal Due Date  Final Torque  Bolt indication (see figure above)  Locking Torque  Final Torque  Accu 1.2  Accu 1.2  Accu 1.2  Accu 1.2  Accu 1.3  Final Torque  Final Torque  Accu 1.2  Accu 1.2  Accu 1.2  Accu 1.2  Accu 1.2  Accu 1.3  Accu 1.5  Acc	VERIFICATION
Torque Wrench- Locking Torque (locking is the same as running torque)  PN XQL Aborg M#  Cal Due Date 6/22/2008  Torque Wrench- Final Torque  PN Same as Running torque  Cal Due Date  Cal Due Date  Bolt indication (see figure above) Locking Torque  Final Torque  Accu 1.2  Accu 1.3  Accu	22. TECH 23. QA/OV
Meca J. 4 10 13 10 27/0	3/02/2009 A. 5/02/2009 A. 5/02/2009 F.
End of online operation PIPE CLAMP to ACCU BRACKETS	

				5. Page 37	AND THE PROPERTY OF THE PARTY O	116
	AMS-02 TASK SHEET (ATS)		4. ATS NO.	ATS	090127-1	-R0
	CONTINUATION PAGE		6. MOD NO.			
20. OPER	21. OPERATIO	ONS			VERIFI	CATION
SEQ. NO.	(Print, Type, or White	e Legibly)			22. TECH	23. QA/DV
9,	RETORQUING OF PELTIER TO ACCU	SADDL	E			
9.1	Prepare the ACCU PIPE CLAMP for RETO inspection of the parts to be re-torqued;	RQUIN	G. Perform a vis	ual		
9.2	Perform a visual inspection of the ACCU B the INSERTS. If necessary clean them with			anliness of al	**************************************	
9.3	Weight all the hardware to be installed, in	ncluding	fasteners. Recor	d the weigh	t	
	TTEM W	VEIGHT				
	Bolt					Т.
	NAS1351N08-12 X8 Washer	<u></u>	W.D	9	Jay	Treon
	NBC1149EN832R x1828	······································	7.99 7		A STATE OF THE STA	
	700					
						***************************************
	SCALE		,	1		A MANAGEMENT OF THE PROPERTY O
9.4	PN AJ -4200 T 320 0757 M#	C	al Date of /14	8000	JCH,	Jason
9.5	WARNING: TTCB installation reference of this ATS.  Verify before use the availability of the approximation of the					
9.5.1	Check the bill of material in the assembly	drawing				

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	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS 090127-1-R0	
	CONTINUATION PAGE	6. MOD NO.		
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)		VERIFICATION  22. TECH   23. QA	/DV
9.5.2	Check the indicated components are installed as si	hown in the figur		
	X 8  (Screw) NAS1351N08-12			
	(Washer) NAS1149E N832R  (Invert) MS21209F0820  Figure 4: Installation of PELTIER TO ACCU SAD	DDLE	AT HEAD AT THE A	
9.5.3	Apply a thin layer of Grease Brancote 601 FF (CI prior the installation (as reported on the assembly CHECK WITH PROJECT ENGINEER HERE  Braycote Grease - PN Lot# /3 + 999 E	drawings).	of each bolt  (6) 2 ° 0 JCH Japan	L
9.6	Install the fasteners as per figure 4 and record fastener hand)  Bolt/washer/nut and number NAS number  Bolt NAS 135 Nog-12 LC  Wather NAS 1149 TN 32 R LC  LC		SYSU  JUE 10/1/20  SYSU  JUE 10/11/20  JUE 10/11/20	2 v

					5 Page 39		116
	AMS-02 TASK SHEE			4, ATS NO.	ATS	090127-1	-R0
	CONTINUATION PA	AGE		6. MOD NO.			
20. OPER SEQ. NO.		21. OPERATI (Print, Type, or Wri				Correspond	CATION
9.7	Torque the fasteners installe torque values are shown in l	ed in the former		e final torque v	alue. Seating	22. TECH	23. QA/DV
		Torque	(in*lbf)				
	Dash Number	Max	Min				
	Screw NAS1351N08-12	26.863	22.83	4			
9.8	Check this value with the ta	ble at the end o	f this ATS				
	Locking torque shall be in 1	.5-15 inch*lbf	(size 0.164	1)			
9.9		ting torque AB	ove loc		AIDC.		
	Torque Wrench- Locking To	orque (locking i	is the same	as running to	rque)		
	PN XQA AAOSO M	[#	Cal I	Due Date 06	132/200	9-91	02/2000
4	Torque Wrench- Final Torqu	ue		caldou	15/55/500	9.	
	PN + QA Mosey M Ask Johannes	#	Cal I	oue Date of caldate	135/2009	29/0	2/2009
AMS Assembly	Task Sheel (ATS) Continuation Rev 9/25/06 JH						

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	AMS-02 TASK SHEET (ATS)  CONTINUATION PAGE	4. ATS NO.	ATS 090	0127-1-R0
	CONTINUATION PAGE	6. MOD NO.		
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)		22	VERIFICATION TECH 23. QA/DV
	Bolt indication (see figure above)  Pelt 1.1 41.0  Pelt 1.4 41.0  Pelt 2.1 41.0  Pelt 2.1 41.0  Pelt 2.1 41.0	ue Fina  24  24  24  24	7.0 7.0 7.0 7.0 7.0 7.0 7.0	Gloc/2009 FUE UE UE UE UE
9.10	Pelt 2.3  Pelt 2.4  Zio  End of online operation PELTIER to ACCU SAD  Locking wire is at		.o_ Ju	E.
			ь	
*	lock wire specs.  5488607 (CESS?  MS20995C32  P/N 5488607 P	na) wire Batch By curch det	lock J dd 1d26 Febrood	v E 26/02/2
Assembly T	ask Sheet (ATS) Continuation Rev 9/25/06 JH			

			ATS 090127-1-R	
	TACK QUEET (ATS)	4, AT\$ NO.	AID OVOID, TI	
	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	6, MOD NO.		
	COMMINOVACIONAL		VERIFICAT	
20. OPER	21, OPERATIONS (Print, Type, or Write Legibly)		22. TECH 2:	3. QA/DV
SEO, NO.				
10.1	INSTALLATION OF TTCS PRIMARY ACCUPRIMARY BASE PLATE  Prepare the TTCS Accumulator for installation. It parts to be installed; clean the parts to be installed the parts to be installed dry on the clean towel.  Prepare screws and washer to be used for the part and washer visual inspection; clean screws and bath and let screws and washers dry on a clean the perform a visual inspection of the base plate inserts. If necessary clean them with Isopropylations.	Perform a visual insp d with Isopropyl Alc rt installation. Perform washers in an Isoprop rowel ; check the cleanlin Alcohol	m a screws pyl Alcohol  ess of all the	
	Weight all the hardware to be installed, inclu	ding fasteners. Reco	ord the weight	l L
10.4	Weight all the hardware to be instance,	ū		}
	ITEM  Bolts.  NASISTEN 36 - 12 x8  Washer.  NASIN TO D363R 78  Thermal Washer.  1t.7 x 0  15.4	7.449 6.169	JcH	Japo
1(	0.5 PN 13-4-20 M#	Cal Date0	58/14/2008 JCH	Jus

			5. Page 42 ATS 0	90127-1-R0
	AMS-02 TASK SHEET (ATS)	4, ATS NO.		
	CONTINUATION PAGE	6. MOD NO.		
	21. OPERATIONS			VERIFICATION  22. TECH 23. QA/DV
20. OPER SEQ. NO.	(Print Type, or Write Legil	bly)	at the start	
10.6	WARNING: for TTCB installation reference of this ATS.  Verify before use the availability of the appropriate the stallation of the stallation reference of this ATS.			
	Verify before use the availability of			-
10.6.1	Check the bill of material in the assembly dr	rawing.		
10.0.				
10.6.2	between washers and base plate and or com  Koropron primer - PN Lot# 310	Exp. Date	4/09.	JCH Japon
10.6.3	Install the indicated component on the TTC	B base plate as shown	in the figure	
10.0.3	below.			
	X8			
	(Screw)NAS1351N3-16		- 4	6a (i)
	(Washer)NAS1149E036	3R		
	THERMAL WASHER-1: 10x5x3	5.3		200
	THERMAL WASHER-1	5.4		93
	10x5x5			A STATE OF THE STA
	Figure 4: Installation of HX supports to	l plata		
		Lo insert		

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	AMS-02 TASK SHEE	ET (ATS)		4. ATS NO.	ATS	090127-1	-R0
	CONTINUATION P	AGE	6	S. MOD NO.			
20. OPER SEQ. NO.		21. OPERAT	TIONS rite Legibly)			VERIFIC 22. TECH	CATION 23. QA/DV
10.6.4	Apply a thin layer of Greprior the installation (as a Braycote Grease - PN	reported on the Lot#_/s	assembly draw	ings).			Jaso
10.7	Install the fasteners as per f hand) Bolt/washer/nut and numbe	670.0	nber	t number (w LOT	rite by		
		351 N3-1				Jc #	Jaso-
	Thermal washer ETS9	08-06-15	LOT#_	U48	by AIDC		
	Thermal washer ETS9	98-06-15.	LOT#	Made Titan	by AIDC		
		-	LOT#_	Tilon	nium		
		-	LOT#_				
		·	LOT#_				
		-	LOT#_		-		
10.8	Torque the fasteners installe torque values are shown in		step to the fina	al torque val	ue. Seating		
	Dash Number	Torque	(in*lbf)				
	Dasii Number	Max	Min				
	Screw NAS1351N3-16	42.237	35.901				
10.9	Check this value with the ta  Locking torque shall be in b			0.190")			

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	AMO OR TACK SHEET (ATS)	4.	ATS NO.	ATS	090127-1-R	
	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	6.	MOD NO.			
					VERIFICAT	
0. OPER	(Print, Ty	OPERATIONS pe, or Write Legibly)			22. TECH 2	3. QA/DV
10.10	Check this value with Table 1 at the serinal torque shall be the seating torque 5% precision on torque.  Accu_Br1.2  Accu_Br1.1  Accu_Br1.3  Figure: Accumulator bolt indications at the sering torque shall be the seating torque	Accu_Br2.2  Accu_Br2.4	Accu_Br2			
	Torque Wrench- Locking Torque (I		is running torque Date $\frac{OS}{N}$ The Date $\frac{OS}{N}$	1. >00 9	Jay	Japon
	Torque Wrench- Final Torque  PN XQUC OII Z  M#	Cal Du	ne Date of //	5/2008	- Jey	Treon
	Bolt indication (see figure above)			Torque	Jey.	Jacon
	Accu_ Ex1.		1		1 / 1 /	-
	Accu Byl. 2	oder der		8.	Jay	
	Accu Byl. 2	oby		\$t	JOH	Joseph
	Accu By1.2 Accu By.1.3			t8	JOH	Jason Jason Jason
	Accu Br.1.3 Accu Br.1.3	- Naph		\$t	JOH JOH JOH	Josep
	Accu-By 1.2  Accu-	2 Oby		t8	JOH	Josep
	Accu Br.1.3 Accu Br.1.3	Haley Hovey		t8 t8	JOH JOH JOH	Joseph Joseph

TICB-P the running torque is larger than specified ranging from 21-26 16 frinch. The highrunning torque us made was not to construction but to the insert. NCR is made was not to construction but to the insert. Approval.

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	AMS-02 TASK SHEET (ATS)		4, ATS NO.	ATS	090127-1	-R0
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20. OPER SEQ. NO.		ERATIONS or Write Legibly)	<del></del> :		VERIFI 22, TECH	CATION 23. QA/DV
				40.4 20.0		
11.	INSTALLATION OF PREHEATER	R ONTO THI	E TTCB BASE I	PLATE		
11.1	Prepare the TTCS PREHEATER for installed; clean the parts to be installed dry on the clean the parts to be a part to be	to be installe	rform a visual in d with Isopropyl	spection of Alcohol and		
11.2	Prepare screws and washer to be used for and washer visual inspection; clean scre- bath and let screws and washers dry on	ws and wash	ners in an Isopro	m a screws pyl Alcohol		
11.3	Perform a visual inspection of the ba inserts. If necessary clean them with Iso	se plate; che propyl Alcol	eck the cleanlin	ess of all the		
11.4	Weight all the hardware to be installe	d, including	fasteners. Reco	rd the weight		
	ITEM	WEIGHT	·			
	Bolt				JcH'	Jacon
	NASIBITZNO40 LIBL X8	4.0			Jon	
	Washer					
	NAS1149ZN43ZR (7ea)	1.	96 g			
	SCALE					
11.5	PN AJ-62006 M#		Cal Date Do / (	4/2008.	JCH	Japon
	3701017 /					
634C Assessed	Fask Sheet (ATS) Continuation Rev 9/25/06 JiH					1

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	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS	090127-1-	KU
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				VERIFIC	
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legbly)			22. TECH	23. QA/DV
11.6	WARNING: for TTCB installation reference draw of this ATS.  Verify before use the availability of the approved				
11.6.1	Check the bill of material in the assembly drawin				
11.6.2		nt. Exp. Date	4/09	JU-1	Jacon
11.6.3	Install the indicated component on the TTCB barbelow.  (Screw) NAS	se plate as show			
11.6.4	Apply a thin layer of prior the installation (as reported on the assemble 19.464).	, to the three	ads of each bol	TUN	Japon
	prior the installation (as reported on the assemble Braycote Grease - PN Lot# 13599				
11.7	Install the fasteners as per figure 4 and record fas hand) Bolt/washer/nut and number NAS number	LOT	or (write of		

					of 1:	RO.
	AMS-02 TASK SHEET	(ATS)	4. ATS NO.	A13 09	,O171-1-	
	CONTINUATION PAG	βE	6. MOD NO.			
		21, OPERATIONS			VERIFIC 22. TECH	23. QA/DV
OPER D. NO.		(Print, Type, or Write Legibly)	LOT#		22. 32011	
-						
	a statement of the stat		_LOT#			
		400 M AT	LOT#			
"			LOT#			
-			LOT#			
-	D 11/	1 MIZENING B-1	LOT#_ &t)	3/2	JUM	Japan
-						
			LOT#LOT#			
	Washer	NOS 1149ZNUSZK	LOT# 9543-11/	K/07_	İ	
			LOT#			
					[ ]	
		elow table	to the final torque va			
	Dash Number	Torque (in*lb				
			of)			
	Dash Number	Torque (in*lb	in			
11.9	Dash Number Screw NAS1352N04LB-6 Check this value with the ta	Torque (in*lb  Max M  7.459 6.3  ble at the end of thi	in 34 s ATS.			And the state of t
11.9	Dash Number Screw NAS1352N04LB-6	Torque (in*lb  Max M  7.459 6.3  ble at the end of thi  between 0.5-5 inc	in 34 s ATS.			
11.9 11.10	Dash Number  Screw  NAS1352N04LB-6  Check this value with the ta  Locking torque shall be in Locking on bolt not as no	Torque (in*lb  Max M  7.459 6.3  ble at the end of thi  between 0.5-5 incinsert is present.	s ATS. ch*lbf (size 0.112)			
	Dash Number Screw NAS1352N04LB-6 Check this value with the ta Locking torque shall be in Locking on bolt not as no	Torque (in*lb  Max M  7.459 6.3  ble at the end of thi  between 0.5-5 incinsert is present.	s ATS. ch*lbf (size 0.112)			
	Dash Number Screw NAS1352N04LB-6 Check this value with the ta Locking torque shall be in Locking on bolt not as no	Torque (in*lb  Max M  7.459 6.3  ble at the end of thi  between 0.5-5 incinsert is present.	s ATS. ch*lbf (size 0.112)			
	Dash Number Screw NAS1352N04LB-6 Check this value with the ta Locking torque shall be in Locking on bolt not as no	Torque (in*lb  Max M  7.459 6.3  ble at the end of thi  between 0.5-5 incinsert is present.	s ATS. ch*lbf (size 0.112)			
	Dash Number Screw NAS1352N04LB-6 Check this value with the ta Locking torque shall be in Locking on bolt not as no	Torque (in*lb  Max M  7.459 6.3  ble at the end of thi  between 0.5-5 incinsert is present.	s ATS. ch*lbf (size 0.112)			
	Dash Number Screw NAS1352N04LB-6 Check this value with the ta Locking torque shall be in Locking on bolt not as no	Torque (in*lb  Max M  7.459 6.3  ble at the end of thi  between 0.5-5 incinsert is present.	s ATS. ch*lbf (size 0.112)			
	Dash Number Screw NAS1352N04LB-6 Check this value with the ta Locking torque shall be in Locking on bolt not as no	Torque (in*lb  Max M  7.459 6.3  ble at the end of thi  between 0.5-5 incinsert is present.	s ATS. ch*lbf (size 0.112)			

1			5. Page 49 c		16
	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS 090	)127-1	-R0
	CONTINUATION PAGE	6. MOD NO.			
20. OPER SEQ. NO.	21. OPERATIONS				CATION
SEQ. NO.	(Print, Type, or Wike Legibly)		22	2. TECH	23. QA/DV
	5% precision on torque.				
	PH_2.2				
		PH_2.1			
	PH 1.2	المراجع المراجع المراجع			
	PH 2.	4			
	PH_1.1	The state of the s			
		PH_2.3			=
	PH_1.4 PH_1.3				
	*				
	Torque Wrench- Locking Torque (locking is the sar	ne as running torqu	ne)		
	PN XQAA 0357 M# Ca	Il Due Date ot/m	12009 Je	CH	Jacon
	Noted that the state terms				
	Torque Wrench- Final Torque  PN \ ARC 000 6  M#  Ca	09/03	/>009		
	PN 1000 8 M# Ca	ll Due Date			
	Bolt indication (see figure above) Locking Torq	ue Final	Torque		
	* DH_7.3 (add waster) 3	/ 0	) J	CH!	Jacon
	> pt1 _ Z. 4 (add washer) /	3	3 ]	C1-1	Jason
	> > H _ 1.3 (add waster)		7.53	CH	Jacon
*	DH 1.4			CH	
				·	Jacon -
-	PH - 7. 1 (addwasher) /			out of	Jasion
	Pri _ 1. C (add wosher)			DEUTEN IN	Joseph
	pH _ 1.   c add washer)		7 7	CH	Jacon
	V DH _ 1. 2 (add ubster) Z		7	CH	Joseph
	Bolt indication (see figure above) Locking Torq	ue Final	Torque		

	AMS-02 TASK SHEET (ATS)	4. ATS NO.	AIS	090127-1	-ICO
	CONTINUATION PAGE	6. MOD NO.			
	OL COURTIONS		4	VERIFIC	CATION
0. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)			22. TECH	23. QA/DV
11.11	End of online operation Pre-heater TTCB-P	not accor	ding		
ā	End of online operation Pre-heater Tres-P  ** Pre-heater was  to specification.  between brockets (an  holes) was slightly  The holes in the be  are enlarged and g  added to allow for	The distant off. ase plate Plight was enough c	ove Shus ontact		
	Rationale.  Pre-hader brackets  structural (not new  The washer soluti  been dicussed with  NCR is in progres	are non- eded). ion has			

					5. Page 51		116 0127-1-R	
<u></u>	A RAC	G-02 TASK SHEET (ATS)		4. ATS NO.	ATS	S 091	0121-1-10	
	MINIC	CONTINUATION PAGE		6. MOD NO.				
1		21. OPERAT	TIONS				VERIFICAT	ION 3. QAVDV
20, OPER SEQ. NO.		(Print, Type, or W	rite Legibly)					
2. INST 12.1 12.2 12.3	Prepare inspection Isopropy Prepare and was bath and Perform inserts.	on OF COLD ORBIT HEATER the TTCS Cold orbit heater prima on of the parts to be installed; clea yl Alcohol and let the parts to be in screws and washer to be used for sher visual inspection; clean screw d let screws and washers dry on a n a visual inspection of the base If necessary clean them with Isop all the hardware to be installed,	ory for instant the part in th	allation. Perf s to be install ry on the clean stallation. Per shers in an Ison el neck the clean ohol	form a visual ed with an towel erform a screws opropyl Alcohological anliness of all	the		
		ITEM Bolt	WEIGH	T				
		NAZITALEN8356 AA Marper NAZITALEN8356 AA		1.49	<u> </u>		JCH	Jacom
- The state of the								
12.	.5 PN	LE AJ-15006 M#		_ Cal Date_	08/14/200	<u>8</u>	JCH	Jaas

			5. Page 52		16
	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS	090127-1-	RO
	CONTINUATION PAGE	6. MOD NO.			
20. OPER	21, OPERATIONS	1	<u>, , , , , , , , , , , , , , , , , , , </u>	VERIFIC	
SEQ. NO.	(Print, Type, or Write Legibly)		ad at the atast	22, TECH	23. QA/DV
12.6	WARNING: TTCB installation reference drawing of this ATS.  Verify before use the availability of the approved	drawing revisio			
12.6.1	Check the bill of material in the assembly drawin				
12.6.2	between washers and base plate and or componer  Koropron primer - PN  Lot#	er of Koropron p nt. Exp. Date	11/09	JCH.	Japon
12.6.3	Install the indicated component on the TTCB bas below.	e plate as showr	in the figure		
		The statement of the st			
	(Scrwe)NAS1352N08-10 (Washer) NAS1149EN832R			And the state of t	
12.6.4	Figure 4: Installation of Cold orbit heater to base  Apply a thin layer of prior the installation (as reported on the assembly Braycote Grease - PN Lot# Lot# Lot# Lot# Lot# Lot# Lot# Lot#	to the thread	Is of each bolt	JeH	Japon
AMS Assembly	Fask Sheet (ATS) Continuation Rev 9/25/06 JH				1

						5. Page 53		116
	AMS-02 TASK SH	EET (ATS)		4	. ATS NO.	ATS	090127-	1-R0
	CONTINUATION	N PAGE		6.	MOD NO.			
20. OPER		21. C	PERATIONS				VERIF	CATION
SEQ. NO.		(Print, Typ	e, or Write Legibly)			·····	22. TECH	23. QA/DV
	VALUE OF THE PARTY							
12.7	Install the fasteners as pe	r figure 4 and	record faste	ners lot	number (w	rite by		
	hand)	_			·			
	Bolt/washer/nut and num	iber NAS	number	1	LOT			
				LOT#_		<del> </del>		
				LOT#_				
		,		LOT#				
	R. 11	MACKETS	N08-10	LO1#	1961	17	TIH	Tream
	POIU	10/12/20	-7/00 10	LOT#_	/ / + 0		1.	230000000
				LOT#				
	Washer	NAS 114	97HV832R	LOT#	77/4-1	0-9-03		
		100000000000000000000000000000000000000						
				******				
		the desired as a factor of the same of the		LOT#				
	SOFF LAN bills bey by dispersion of the soft of the so		]	LOT#	A LUCIONE DE LE CONTRACTOR DE			
12.8	Torque the fasteners instatorque values are shown i	lled in the for	mer step to	the final	torque val	ue. Seating		
	torque values are shown i	ii below table						
		Torque	(in*lbf)	<u>-</u>				
	Dash Number	Max	Min					
	Screw							
	NAS1352N08-10	24.944	21.203					
	NAS1332N00-10							
12.9	Check this value with the	table at the er	nd of this A'l	rs.				
	Locking torque shall be in	hetween 1.5-	- 15 inch*lb	ıf				
10.10				•				
12.10	Check this value with Tab Final torque shall be the s				TOROUE	t.		
1	5% precision on torque.			3121110	1011401	•		
\MS Assembly T	ask Sheet (ATS) Continuation Rev 9/25/06 JH							

	AMS-02 TASK S			4. ATS NO.		54 ATS 090	012	
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. OPER EQ. NO.			PERATIONS o, or Write Legibly)					FICATION
ì						22	2. TECH	23. QAVD\
		110						
		andre in the state of the state						
	The second secon	CO 2	.4					
45	CONTROL OF STREET		. 1 6					
	CO_1.2		СО	2.3				
		00 11	PARTY STREET					A CONTRACTOR OF THE PERSON OF
		CO1,1						,
	- and the second							
							1	,
1 1 4	Oronio III and I and	CCC					- 1	
10	orque Wrench-Lockin							
Pì	V XGUICOID					>		
Pi	Natural Tolls					FL	H	Jacon
Pr To PN	NXGUICOIIV  Orque Wrench-Final T  NXGK (OCT 3	M# 'orque M#	Cal I	Due Date $\frac{\partial^2}{\partial \delta}$ Due Date $\frac{\partial^2}{\partial \delta}$	1/1 /2008 1/1 /2008		H	Japon
Pr To	N XGU   COIIV prque Wrench- Final T N X Q C OUT 3 Polt indication (see figu	M# 'orque M#	Cal I	Due Date $\frac{\partial^2}{\partial \delta}$ Due Date $\frac{\partial^2}{\partial \delta}$	1/1 /2008 1/1 /2008		H	Japon
Pr To	N XGU   COllar prque Wrench- Final T N X Dk C 0243 Polt indication (see figure CO_7.3	M# 'orque M#	Cal I	Due Date $\frac{\delta}{\delta}$ Due Date $\frac{\delta}{\delta}$	1/1 /2008 1/1 /2008	Jet	-	Jaeon
To PN	N XGU   COIIV prque Wrench- Final T N X Q C OUT 3 Polt indication (see figu	M# 'orque M#	Cal I  Cal I  Cal I	Due Date $\frac{\delta}{\delta}$ Due Date $\frac{\delta}{\delta}$ Fin $\frac{234}{\delta}$	14/2008 14/2008 4/2008 al Torque	Jet	-	Jaeon
To PN	N XGU   COllar prque Wrench- Final T N X Dk C 0243 Polt indication (see figure CO_7.3	M# 'orque M#	Cal I  Cal I  Cal I  king Torque	Due Date $\frac{\partial^2 f}{\partial \delta}$ Due Date $\frac{\partial^2 f}{\partial \delta}$	14/2008 1/4/2008 1/4/2008 al Torque	Jet	-	Jaeon
Pr To	N XGU   COllar orque Wrench- Final T N X Ok C 0243 Olt indication (see figure CO_z. 3	M# 'orque M#	Cal I  Cal I  Cal I  king Torque	Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$ Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$	14/2008 114/2008 115/2008 al Torque 10=33 36	Jet	-	Jaeon
Pr To PN	N XGU   COllar prque Wrench- Final T N X De C 0243 Polt indication (see figure CO_7.3 CO_7.4 CO_1.	M# 'orque M#	Cal I  Cal I  king Torque  / ©  / 3	Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$ Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$	14/2008 14/2008 al Torque 10:33 36	Jet	-	
Pr To PN	N XGU   COllar prque Wrench- Final T N X De C 0243 Polt indication (see figure CO_7.3 CO_7.4 CO_1.	M# 'orque M#	Cal I  Cal I  king Torque  / ©  / 3	Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$ Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$	14/2008 14/2008 al Torque 10:33 36	Jet	-	Jaeon
Pr To PN	N XGU   COllar prque Wrench- Final T N X De C 0243 Polt indication (see figure CO_7.3 CO_7.4 CO_1.	M# 'orque M#	Cal I  Cal I  king Torque  / ©  / 3	Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$ Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$	14/2008 14/2008 al Torque 10:33 36	Jet	-	Jaeon
Pr To PN	N XGU   COllar prque Wrench- Final T N X De C 0243 Polt indication (see figure CO_7.3 CO_7.4 CO_1.	M# 'orque M#	Cal I  Cal I  king Torque  / ©  / 3	Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$ Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$	14/2008 14/2008 al Torque 10:33 36	Jet	-	Jaeon
Pr To	N XGU   COllar prque Wrench- Final T N X De C 0243 Polt indication (see figure CO_7.3 CO_7.4 CO_1.	M# 'orque M#	Cal I  Cal I  king Torque  / ©  / 3	Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$ Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$	14/2008 14/2008 al Torque 10:33 36	Jet	-	Jaeon
Pr To PN	N XGU   COllar prque Wrench- Final T N X De C 0243 Polt indication (see figure CO_7.3 CO_7.4 CO_1.	M# 'orque M#	Cal I  Cal I  king Torque  / ©  / 3	Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$ Due Date $\frac{\partial \mathcal{S}}{\partial \mathcal{S}}$	14/2008 14/2008 al Torque 10:33 36	Jet	-	Jaeon

			5. Page 55	of 1	16
	AMS-02 TASK SHEET (ATS)	4, ATS NO.	ATS	090127-1-	·R0
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T	21, OPERATIONS			VERIFIC	
20. OPER SEQ. NO.	(Print, Type, or Write Legibly)			22. TECH	23. QAVDV
- Complete Control of the Control of	Bolt indication (see figure above) Locking Tore	que Fir	nal Torque		
12.11	End of online operation cold orbit heater				
				A later reprinted to the state of the state	
					-
	)				Company Variation and Company Variation and
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:	y Task Sheet (ATS) Continuation Rev 9/25/06 JH				

Flight installation on Flight vadiator see Addendum II. Po6-p60

				5. Page	56	of	116
	AMS-02 TASK SHEET (ATS)  CONTINUATION PAGE		4. ATS NO	).	ATS	090127-	1-R0
	CONTINUATION PAGE		6. MOD NO	р.			
20. OPER SEQ. NO.		ERATIONS or Write Legibly)				VERII 22. TECH	FICATION 23. QA/DV
13.1 13.2 13.3	Prepare the TTCS PUMP for installation to be installed; clean the parts to be installed parts to be installed dry on the clean tow Prepare screws and washer to be used for and washer visual inspection; clean screwath and let screws and washers dry on a Perform a visual inspection of the basinserts. If necessary clean them with Ison	n. Perform a valled with Isovel or the part ins ws and washe a clean towel	visual insperpropyl Alcorate tallation. Pers in an Is	ection of the cohol and let erform a scr opropyl Alco	parts the ews ohol		25. GAUDY
13.4	Weight all the hardware to be installed	T	fasteners. I	Record the	weight		
	Bot NACRETURENTES X8 Washer NAS 1149 ENLESZE X8 Nucl. NACRETURENTES	WEIGHT //. 4. 4. 5. 7.	72 6 18 6 88 9	<i>Y</i>		JCH	Jacon
13.5	SCALE PN AJ-UNOTE M#	Ca	al Date_O	s/14/20	08	JoH.	Jacon

## p 56- p60 See Addendum II

CONTINUATION PAGE  21. OPERATIONS (Print Type, or Write Legibly)  ARNING: TTCB installation reference draw this ATS. rify before use the availability of the approve the bill of material in the assembly draw apply a thin is ween washers and base plate and or composite to propron primer - PN	wings are as indicate wed drawing revision wing.  ayer of Koropron proment Exp. Date	d at the start	090127-1 VERIFI 22. TECH	CATION 23. OAVD
ARNING: TTCB installation reference draw this ATS.  rify before use the availability of the approximately before use the availability of the approximately draw apply a thin law the washers and base plate and or composition of the approximately apply a thin law to be apply a thin law to be applied to be appl	wings are as indicate wed drawing revision wing.  ayer of Koropron proment Exp. Date	imer in $U/09$ .	22. TECH	23. QA/D
ARNING: TTCB installation reference draw this ATS.  rify before use the availability of the approximate the bill of material in the assembly draw apply a thin laween washers and base plate and or comport ropron primer - PN	wings are as indicate wed drawing revision wing.  ayer of Koropron proment Exp. Date	imer in $U/09$ .	22. TECH	23. QA/D
ARNING: TTCB installation reference draw this ATS.  rify before use the availability of the approximately before use the availability of the approximately draw apply a thin law the washers and base plate and or compositely apply a thin law to proprom primer - PN	wings are as indicate wed drawing revision wing.  ayer of Koropron proment Exp. Date	imer in $U/09$ .		
this ATS.  rify before use the availability of the approximate the bill of material in the assembly draw apply a thin laws ween washers and base plate and or comport for primer - PN Lot#	wing.  ayer of Koropron property Exp. Date	imer in $U/09$ .	Jсн	Jamos
apply a thin lawer washers and base plate and or comporting the property of th	ayer of Koropron proment.  Exp. Date	4/09.	Jсн	Jamos
ropron primer - PN Lot#	Exp. Date	4/09.	Jсн	Japo
tall the indicated component on the TTCB t		in the figure		10
tall the indicated component on the TTCB tow.	base plate as shown	in the figure		5
		1		
(Washer) NA	S1149EN532R			
	(Screw) 1 (Washer) NA	PAGE PAGE	(Screw) NAS1352N06-10  (Washer) NAS1149EN532R	(Screw) NAS1352N06-10  (Washer) NAS1149EN532R

p56-p60 See addendum II.

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	AMS-02 TASK SI CONTINUATIO	and the second s	*	4. ATS NO.	AIS	090127-	1-R0
	I GONTINO/NIO	MITAGE		6. MOD NO.	*	4.5	
20. OPER SEQ. NO.			OPERATIONS pe, or Write Legibly)			. VERIF	23. QA/DV
13.6.4	prior the installation ( Braycote Grease - PN	as reported or  Lo  24/2  77 201-ΔM	the assembly the second of the	Exp. Date 06 62	.68.	EH	Jacon
13.7	Install the fasteners as poland) Bolt/washer/nut and nun	er figure 4 and	I record fastene S number	ers lot number (wri	te by		
			LC	OT#			
	Boll	NAS 131	> 1/1/ /s	DT# 8f47	8	JUY	Japon
	Washer	NASTIY	10 PENSON LO	OT#_ UOOF	3		
-	Not	NASI	91 COLM LO	ot#			
				T#			
13.8	Torque the fasteners instatorque values are shown i	illed in the for n below table	mer step to the	e final torque value	. Seating		
	D-IN-I	Torque	(in*lbf)				
	Dash Number	Max	Min		1		
	Screw NAS1352N06-10	13.861	11.782				
13.9	Check this value with the	table at the en	d of this ATS.			ŀ	
]	Locking torque shall be in	between 1-1	0 inch*lbf (siz	ze 0.138).			
	Check this value with Tab Final torque shall be the so 5% precision on torque.	le 1 at the star eating torque	rt of this ATS. ABOVE LOCK	KING TORQUE.			

## p 56-p60 See Addendum II.

	AMS-02 TASK SUFE	7/1		5. Page 59	of 116
	AMS-02 TASK SHEE	(ATS)	4. ATS NO.	ATS	090127-1-R0
	TOWN PA	AGE.	6 1105		
20. OPER SEQ. NO.		24 Opening	6. MOD NO.		10
		21. OPERATIONS (Print, Type, or Write Legibly)			VERIFICATION
					22. TECH 23.
	(a) (a) (b)		1. (7)		
	Pmp_1.2	TERM THE TERMS TO	NE.		
1		Pmp_1.4			+
	Pmp .1.1				
1	- HP1.1	Pmp_1.3		1	
1	P 2.2	Dmm 2		ı	
	Pmp_2.2	Pmp_2.4	4		
		FCACO <u>AT</u>			
	7/	THE PARTY OF THE P	3.262 B	1	
	Pmp_2.1	Pmp_2.3			
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1	Corque Wrench- Locking Torque VF AAUS of	ue (locking is the same	as running torque		1
P	NXQAAO309 MH	(Patricular)	oraning torque	' 1_	
	17177	Cal D	ue Date 6/22	1209 7	41 Jason
T	order Wichell- Final Lorque				
PN	VAAAA			· ·	
111	M#_	Cal Du	ie Date 0//22/	2009	
Bo	olt indication (		0/2-/		1
	olt indication (see figure abov	(e) Locking Torque	Final To	rque 7	14 Japon
_	1 - 1.7	颇为9	1011	rque L	1 Javeon
	pmp_7.1		- is 17	-16 26 1CP	7. torque
-	L- 12 F	_ 9 6	18- 12	1-	(14) -
	Pmp_ 7.4	19 6			H. Jason
	דר קייוק	1-0 0	R 12	Jc	H Jason
	7.7	Ø €	P 12		- WOON
1	1.1 _ des		12	_ Ju	7 Jason
1-7		_ 9	15	Jo	3 20
1	Smp 1.2	7			120000
	hm.		13	_ Ju	H T-101
	bmp - 1.3	7	13		
			17	_ J4	1 Jason
1	pmp-1.4	/0	16	Jar	
			/ 6	-	Jacon
			1	1	
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p36-p60 See also Addendum II.

	AMS-02 TACK OUTER			5. Page 60	of 116
	AMS-02 TASK SHEET (ATS CONTINUATION PAGE	5)	4. ATS NO.	ATS	090127-1-R0
0. OPER EQ. NO.			B. MOD NO.		
EQ. NO.	(Print	21. OPERATIONS , Type, or Write Legibly)			VERIFICATION
	Bolt indication (see figure above)	Locking Torque	Final	Torque	22. TECH 23. QA
3.11	End of online operation pumps				
	1 · · · · · · · · · · · · · · · · · · ·				

	AMS-02 TASK SHEET (ATS	3)	4 ATO NO	5. Page 61 ATS	od 090127-∃	116 L-RO
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SEQ. NO.	(Print	21. OPERATIONS . Type, or Write Legibly)				CATION
				····	22. TECH	23. QA
4 79 700						
4. INS	ALLATION OF CONNECTOR PL	ATE TO BOX C	COVER			
14.1	Prepare the CONNECTRO PLATE	for in a till at the				
	the parts to be installed; clean the part let the parts to be installed dry on the	rts to be installed	with Isopropyl	Ispection of Alcohol and		
145	was and on the	cicati towel		į		
14.2	Prepare screws and washer to be used and washer visual inspection; cleans	I for the part insta	allation. Perform	a screwe		
	and washer visual inspection; clean so bath and let screws and washers dry o	crews and washe	rs in an Isopropy	l Alcohol		
14.3	ary c	ma cican tower				
	Perform a visual inspection of the RIVNUTS. If necessary clean them w	COVER check	the cleanliness	of all the		
14.4	,	in isopropyt AI(	conor			
14.4	Weight all the hardware to be install	led, including fa	steners. Record	the weight	-	
				0,110		
	ITEM				-	
		WEIGHT			_	
	Bolts (NASIB FZ NOGEB-8) >	41080	17.29		Cy J	120W
}					r	
	Washer (NAS1149EN6321	D v 1571	+ / ~			
	[010]	Kriver	J. 69			
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			<b></b>			
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		<del> </del>				***************************************
	CALE					
.5 ]	37-1200E M#		201111			
	3-0107kg M#	Cal D	ate	Det Jet	Juce	97L
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	AMS-02 TASK SHEET (ATS)	4.570.07	5. Page 62 ATS	090127	116 1 RO
	CONTINUATION PAGE	4. ATS NO, 6. MOD NO.	*****		-1-10
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)		·	VER	FICATION
14.6	WARNING: TTCB installation reference drawin of this ATS.  Verify before use the availability of the approved		at the start	22. TECH	23. QA/E
14.6.1	Check the bill of material in the assembly drawing			**************************************	
14.6.2	between washers and base plate and or componen	+			
14.6.3	Koropron primer - PN Lot# 3706±3  Install the indicated component on the TTCB base below.	Exp. Date 4	he figure	Јсн	Jason
	(Screw) NAS1352No (Washer) NAS1149EN				

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	CONTINUA	TION PAGE	7			7 070127	-1-10
20, OPER SEQ. NO.			21. OPERATIONS	6, MOD NO.		T WED	15:01
14.6.	Apply a thin laws		nt, Type, or Write Legibly)			22. TECH	IFICATION 23, OA
14.7	prior the installation	in (as reported  N	Lot# 135999  AS number  NollB-8  LO  N532R  LO  LO	Exp. Date 666  ers lot number (with LOT OT# No info)  OT# U00 53  OT# U00 53	rite by	Jey Jey	Jacon Jacon
-			LO				
_			LO'				
4.8 T to	Orque the fasteners instorque values are shown  Dash Number	1	rmer step to the	final torque value.	Seating		
1		Max	Min				
	Screw NAS1352N06-6	13.861	11.782				
1	eck this value with the						
Loc	cking torque shall be in	between 1-1	0 inch*lbf (size	0.138).			
.10 Che	eck this value with Tab al torque shall be the se precision on torque.	le 1 at the eter	t of the A TO				

CONTINUATION PAGE  6. MOD NO.  21. OPERATIONS	> 0 x 7 \ T - T C O.	ATS 0901	4. ATS NO.	(A15)	AMS-02 TASK SHEET	
21. OPERATIONS			6. MOD NO.	E	CONTINUATION PAG	
V 10% Type, the verifie Legible)	VERIFICATION			21. OPERATIONS (Print, Type, or Write Legibly)		0, OPER SEQ. NO.
	22. TECH 23. C	22.				Water
BC_1 BC_2 BC_3 BC_7 BC_8 BC_9 BC_10 BC_10				BC_7 BC_8	BC_2 BC_3 BC_4	
Torque Wrench- Locking Torque (locking is the same as running torque)  PN XQAA 0357 M# Cal Due Date 5/20/2009 Jc  Torque Wrench- Final Torque  PN XQAA 0357 M# Cal Due Date 05/20/2009 Jc	H Jacon		ue Date	e (locking is the same  Cal D  Cal D	e Wrench-Final Torque  GAA 035   M#	PN XC Torque
PN XQAA 035   M#   Cal Due Date 04/20/2009 ]C  Torque Wrench- Final Torque  PN XQAA 035   M#   Cal Due Date 04/20/2009 ]C  Bolt indication (see figure above) Locking Torque   Final Torque	EH Jacon	2009 JCH 12009 JCH rque	ue Date <u>of/20/20</u> Le Date <u>of/20/20</u> Final Torqu	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	EAA 03.5   M#  The Wrench-Final Torque  TO AA 03.5   M#  Indication (see figure above	PN XC Torque PN X
PN XQAA 035   M# Cal Due Date 04/20/2009 JC  Torque Wrench- Final Torque  PN XQAA 035   M# Cal Due Date 04/20/2009 JC  Bolt indication (see figure above) Locking Torque Final Torque  BC   /3.5 JC		2009 JCH 12009 JCH rque	ue Date <u>of/20/20</u> Le Date <u>of/20/20</u> Final Torqu	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	EAA 03.5   M#_  e Wrench- Final Torque  EAA 03.5   M#_  Idication (see figure above)	PN XC Torque PN X
PN XQAA 035   M#   Cal Due Date \( \frac{1}{2} \rangle \) \( \sqrt{20} \) \( \frac{7}{200} \) \( \frac{7}{	H Japon	2009 JCH 12009 JCH rque JCH	ue Date <u>of</u> /20/20  Final Torqu / 3. 5	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	EAA 03.5   M#_  e Wrench- Final Torque  EAA 03.5   M#_  Idication (see figure above)	PN XC Torque PN X
PN XQAA 035   M# Cal Due Date 4/20/2009 JC  Torque Wrench- Final Torque  PN XQAA 035   M# Cal Due Date 05/20/2009 JC  Bolt indication (see figure above) Locking Torque Final Torque  BC   /3.5 JC  -3 / JC	H Jacon H Jacon	2009 JCH 12009 JCH rque JCH JCH	ue Date 4/20/20/20/20/20/20/20/20/20/20/20/20/20/	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	SAA 03.5   M#_ee Wrench- Final Torque  AAA 03.5   M#_ee Wrench	PN XC Torque PN X
PN XQAA 035   M# Cal Due Date 4/20/2009 JC Torque Wrench- Final Torque PN XQAA 035   M# Cal Due Date 05/20/2009 JC  Bolt indication (see figure above) Locking Torque Final Torque BC 1 /3.5 JC  -3 /3 JC	H Japon H Japon	2009 JCH 12009 JCH rque JCH	ue Date 4/20/20/20/20/20/20/20/20/20/20/20/20/20/	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	SAA 03.5   M#  e Wrench-Final Torque  GAA 03.5   M#  Idication (see figure above  3.6   2.7   2.7   3.8	PN XC Torque PN X
PN XQAA 035   M#   Cal Due Date \( \frac{1}{2} \rightarrow \) \( \frac{1}{2} \rightarrow \) Torque Wrench-Final Torque \( \frac{1}{2} \rightarrow \) \( \fra	H Japon H Japon H Japon	2009 JCH 12009 JCH rque JCH JCH JCH JCH	ue Date 4/20/20/20/20/20/20/20/20/20/20/20/20/20/	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	SAA 03.5   M#  e Wrench-Final Torque  GAA 03.5   M#  Idication (see figure above  3.6   2.7   2.7   3.8	PN XC Torque PN X
PN XQAA 035   M#   Cal Due Date \( \frac{1}{2} \) \( \frac{1}{2} \	H Japon H Japon H Japon H Japon	>009 JCH  12009 JCH  rque  JCH  JCH  JCH  JCH  JCH	ue Date 4/20/20/20/20/20/20/20/20/20/20/20/20/20/	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	SAA 03.5   M#  e Wrench-Final Torque  GAA 03.5   M#  Idication (see figure above  3.6   2.7   2.7   3.8	PN XC Torque PN X
PN XQAA 035   M#   Cal Due Date \( \frac{1}{2} \) \( \rangle \) \( \frac{1}{2} \) \(	H Jacon H Jacon H Jacon H Jacon H Jacon	>009 JCH  12009 JCH  rque  JCH  JCH  JCH  JCH  JCH  JCH  JCH  JC	ue Date 4/20/20  Final Torqu /3.5 /3.5 /3 /9	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	SAA 03.5   M#  e Wrench-Final Torque  GAA 03.5   M#  Idication (see figure above  3.6   2.7   2.7   3.8	PN XC  Torque  PN X
PN XQAA 035   M# Cal Duc Date 4/20/2009 Jo Torque Wrench- Final Torque PN XQAA 035   M# Cal Due Date 05/20/2009 Jo Bolt indication (see figure above) Locking Torque Final Torque BC   /3.5 Jc -3   /3 Jc -4   /3 Jc -5   /3 Jc -6   /5 Jc -7 Jc	H Jacon H Jacon H Jacon H Jacon H Jacon H Jacon H Jacon	>009 JCH  12009 JCH  TGH  JCH  JCH  JCH  JCH  JCH  JCH  JCH  J	ue Date 4/20/20/20/20/20/20/20/20/20/20/20/20/20/	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	SAA 03.5   M#  e Wrench-Final Torque  GAA 03.5   M#  Idication (see figure above  3.6   2.7   2.7   3.8	Torque PN XC PN XC
PN XQAA 035   M# Cal Duc Date 4/20/2009 Jo Torque Wrench- Final Torque PN XQAA 035   M# Cal Due Date 05/20/2009 Jo Bolt indication (see figure above) Locking Torque Final Torque BC   /3.5 Jc -3   /3 Jc -4   /3 Jc -5   /3 Jc -6   /5 Jc -7 Jc	H Jacon H Jacon H Jacon H Jacon H Jacon H Jacon H Jacon	>009 JCH  12009 JCH  rque  JCH  JCH  JCH  JCH  JCH  JCH  JCH  JC	ue Date 4/20/20  Final Torqu /3.5 /3 /3 /3 /3 /3 /3	e (locking is the same  Cal D  Cal D  Cal D  Colore  Locking Torque	SAA 035   M#  e Wrench-Final Torque  GAA 035   M#  Indication (see figure above  3	Torque PN XC PN XC

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20. OPER SEQ. NO.		2d Opening	8. MOD NO.			
SEQ. NO.	(Prin	21. OPERATIONS II. Type, or Write Leg(bly)		·	VERII 22. TECH	FICATION 23. QA/D
	Bolt indication (see figure above)  BC9  - /b	Locking Torque	Final	Torque	JCH IEH	Jason
14.11	End of online operation cover and	connector plate				
A description of the second of						
	ret (ATS) Continuation Rev 9/25/06 JH					



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	CONTINUATION PAGE	6, MOD NO.			·
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)		···	VERIF	TICATION 23. QA/DV
15. 15.1	INSTALLATION OF Cover to CoverRibs (PPB)  Prepare the Cover and Cover ribs for installation. Pe the parts to be installed; clean the parts to be installed.	erform a visual in	spection of		
15.2	let the parts to be installed dry on the clean towel  Prepare screws and washer to be used for the part in and washer visual inspection; clean screws and washath and let screws and washers dry on a clean tower.	nstallation. Perfor hers in an Isopro	m a screws		
15.3	Perform a visual inspection of the COVER che RIVNUTS. If necessary clean them with Isopropyl A	ck the cleanline Alcohol	ess of all the		
15.4	ITEM WEIGHT  BOH  Washer  WAS 11492N 532P) ************************************			Jul	Jason
15.5	SCALE PN AJ - 4500 E PN 370   0757  M# C  ask Sheet (ATS) Continuation Rev 9/25/05 JH	Cal Date 08 / 14	/ >008	JcH	Japoni

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	AMS-02 TASK SHEET (ATS)	4. ATS NO.	AIS	090127-	1-K0
	CONTINUATION PAGE	8, MOD NO.			
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)	<u> </u>	· <del>/ </del>		CATION
15.6	WARNING: TTCB installation reference drawing of this ATS.  Verify before use the availability of the approved			22. TECH	23. QA/DV
15.6.1	Check the bill of material in the assembly drawing	3.			
15.6.2	apply a thin layer between washers and base plate and or component sk-700/910-704  Koropron primer - PN Lot#	of Koropron pr t. Exp. Date		JoH	Jacon
15.6.3	3/06仕 Install the indicated components as shown in the fi				
	EXC ALC ATT.  FOR A CONTROL OF THE STATE OF				
AMC Accombly Tool	k Sheet (ATS) Continuation Rev 9/25/06 JH	·			

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	AMS-02 TASK SHEET (ATS)	4. ATS NO.		090127-	
	CONTINUATION PAGE	4. ATO NO.			
	SOM MONTON NOE	6. MOD NO.			
20. OPER	21. OPERATIONS			VERII	FICATION
SEQ. NO.	(Print, Typa, or Write Legibly)	······································	·	22. TECH	23. QA/DV
15.6.4	(Screw) NAS13521  (Washer) NAS11491  (Washer) NAS11491  (Washer) NAS11491  (Washer) NAS11491  End of the installation of cover on ribs  Apply a thin layer of prior the installation (as reported on the assembly of bolt-the layer)  Braycote Grease - PN Lot#   35999 End of the layer of bolt-the l	N06-6 EN532R  X 25  , to the threads of eathravings)		JeH	Jaeon

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CONTINUATION						
T	21. OPERAT	TIONS	MOD NO.		VERI	FICATION
Install the fasteners as per	(Print, Type, or Wi				22. TECH	23. QA/DV
	ASII4 PENESS	LOT#_/	OT Jo inf Avanti 10053	ormation igo266	Jen	Jason
	-	LOT#_			a "	
Torque the fasteners install torque values are shown in	below table.	step to the final	torque valı	ne. Seating		
Torque the fasteners install torque values are shown in Dash Number	Torque	step to the final	torque valu	ie. Seating		
torque values are shown in	below table.	step to the final	torque valu	te. Seating		

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	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS	090127-	-1-R0
	CONTINUATION PAGE	6. MOD NO,			
20. OPER	21. OPERATIONS		Admitted or a second or a seco	VER	IFICATION
SEQ. NO.	(Prìnt, Type, or Write Legibly)			22. TECH	23. QA/DV
	CV_2  CV_3  CV_4  CV_8  CV_8  CV_9	CV_5 CV_6 CV_7  V_11 CV_12 CV_13  CV_14			
	CV_16  CV_16  CV_17  CV_19  CV_20	CV_21 CV_22 CV_23 CV_24 CV_25			
	Torque Wrench- Locking Torque (locking is the same PN AA つまり M# Call Torque Wrench- Final Torque	e as running torqu امراح) Due Date	1e) >009	JCH	Jazon Jazon
	PN XQAA0357 M# Call	Due Date 05/20	12009	JCH	Jaeon

	AMS-02 TASK SHEET (ATS CONTINUATION PAGE	3)	4. ATS NO.	AI	S 090127-	1-RU
). OPER		21. OPERATIONS	6. MOD NO.		VERI	FICATION
EQ. NO.	Bolt indication (see figure above)	t, Type, or Write Legiply)	a 17%	nal Torque	22. TECH	23. QA
	CV_	3.5		5,5	JUH	Jaco,
	CV-2	3	***************************************	15	JUH	Jaeo
	CV-3	3		15	JCH	Joan
	CV-4	3	***************************************	15	JCH	Jaco
	CV.5	2		4.5	JCH	Jaso
İ	OV_6	1.5	/	3.	Jul	Jack
	<u> </u>	1.5		3.5	Jay	Jaeo
one and the second	CV-8	2		14	JCH	Japa
	CV-9	3	/	4	Ja1	Jose
	CV-10	4	/	16	Jay	Jaso
	CV-11	3 :		15	JCH	Jaso
	W-12	4		16	JC14	Jaco
		<u>3</u>		<u>J</u>	J 017	Jose
	CV-14	3		5	Jelf	Jes
	CV_15	1.3	<del>'</del> ,	3,5	JCH	Japo
	CV_16	1.5	/	3.5	JCH Told	Joses.
	<u> </u>				Jay	Jaco
	CV_18			14	JCH.	Jaco
	CV_ 19	3	***************************************	13 1 V	J4 T.,	Joilo
	CV_ vo	7.5		101	JCH	Jazon -
-	CU_ \( \) \( \)	7.5		4.5 4.5	JCH JCH	Japp
-	CU_>2	<u> </u>		7,_1		Jason

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0. OPER SEQ. NO.	(Print	21. OPERATIONS , Type, or Write Legibly)	••		VERIJ 22. TECH	FICATION 23. QAT
	Bolt indication (see figure above)	Locking Torque	e F	inal Torque		
	CV_ 23	z. <i>\$</i>		111.6	Jug	Jaso
	CV_23 CV_24 CV_X	1. 5		3, 5	J47 J44 J64	Joeson
	CV-25	3		13	JCH	Jacob
			Miles and an and			
				TTT TO A STORE OF THE PARTY OF		
			· · · · · · · · · · · · · · · · · · ·			
	End of online operation cover to ri	ibs installation				
	End of online operation cover to ri	ibs installation				77
	End of online operation cover to ri	ibs installation				
	End of online operation cover to ri	ibs installation				
The second secon	End of online operation cover to ri	ibs installation				7.04.
	End of online operation cover to ri	ibs installation				
	End of online operation cover to ri	ibs installation				
	End of online operation cover to ri	ibs installation				
	End of online operation cover to ri	ibs installation				
	End of online operation cover to ri	ibs installation				
	End of online operation cover to ri	ibs installation				
	End of online operation cover to ri					
	End of online operation cover to ri					
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	End of online operation cover to ri					

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	AMS-02 TASK SHEET (ATS)  CONTINUATION PAGE	4. ATS NO.			
	Ţ	6, MOD NO.		<del></del>	
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)		•	VERIF 22. TECH	ICATION 23. QAVDV
16. 16.1	INSTALLATION OF FRONT COVER RIB TO  Prepare the FRONT COVER RIB for installation. Pe the parts to be installed; clean the parts to be installe let the parts to be installed dry on the clean towel	erform a visual in		· · · · · · · · · · · · · · · · · · ·	
16.2	Prepare screws and washer to be used for the part in and washer visual inspection; clean screws and wash bath and let screws and washers dry on a clean towe	ners in an Isoprop			
16.3	Perform a visual inspection of the BASE PLATE of INSERTS. If necessary clean them with Isopropyl A		ess of all the		
16.4	Weight all the hardware to be installed, including	fasteners. Recor	d the weight		
	ITEM WEIGHT				
	Bolt NAS1352NO8-8 XZ Washer	3.76 g		JCH	Jacon
The state of the s	NASII49EN83ZRXZ O	.72 g			
16.5	SCALE PN	Cal Date	800<	JcH	Japon
AMS Assembly	Task Sheet (ATS) Continuation Rev 9/25/06 JH				

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20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)	J		VERI 22. TECH	FICATION 23. QA/DV
16.6.1	WARNING: TTCB installation reference drawing of this ATS.  Verify before use the availability of the approved Check the bill of material in the assembly drawing	drawing revision			
16.6.2	between washers and base plate and or component AL-Joo/910-704  Koropron primer - PN Lot#370	of Koropron pr t. Exp. Date	imer in	Joh	Isson
16.6.3	Install the indicated components as shown in the fi	igure below.			

	AMS-02 TASK SHEET (ATS)	4. ATS NO.	5. Page 75 ATS	090127~	116 1-R0
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20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)			VERII 22. TECH	FICATION 23. QA/DV
16.6.4 App Brain Bol Was	t/washer/nut and number NAS number  L  L  L  L  L  L  L  L  L  L  L  L  L	ers lot number (v	of each bolt  or 8  vrite by  -9-03	JeH	Jason

	AMS-02 TASK SHEE			4. ATS NO.	ATS	090127	116 -1-R0
20. OPER SEQ. NO.		21, OPERA		6. MOD NO.		VEF	IFICATION
16.8	Torque the fasteners installe torque values are shown in	ed in the former below table.		final torque va	alue. Seating	22. TECH	1 23. QA
	Dash Number	Torque	(in*lbf)				
	Screw	Max	Min				
	NAS1352N08-8	24.944	21.203				
16.9	Check this value with the ta	ble at the end o	of this ATS.				
	Locking torque shall be in b	etween 1.5 – 1	5 inch*lbf (	size 0.164).	TOTAL MENT OF COLORS		;
6.10	Check this value with Table Final torque shall be the sea 5% precision on torque.			ING TORQU	В.		
	Torque Wrench- Locking To  PN XOW ON MA  Torque Wrench- Final Torque	#	s the same a Cal Du	ie Date 08/13	/2009	Jely	Jaeon

	AMS-02 TASK SHEET (ATS	5)	4. ATS NO.	ATS	S 090127-	1-R0
	CONTINUATION PAGE		6. MOD NO.			
20. OPER SEQ. NO.	21. OPERATIONS (Print, Typo, or Write Legibly)			VERIF 22, TECH	CATION 23, QA/DV	
	Bolt indication (see figure above)  Front, Luc.	Locking Torque		al Torque		
	Front base 2	13		6		Jacon
	-		<u></u>			
16.11	End of online operation cover to f	ront cover rib to	base plate			
					ŀ	
					non-negative de la constante d	
					1	
						;
						ļ
Assessed	sk Sheet (ATS) Continuation Rev 9/25/06 JH					

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	AMS-02 TASK SHEET (ATS)		4. ATS NO.	ΓA	ΓS 090127	-1-R0
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20. OPER SEQ. NO.		ERATIONS or Write Legibly)			VER	RECATION
17.	INSTALLATION OF Cover to Base p	late rivnuts 1				
17.1	Prepare the Cover for installation. Perfor installed; clean the parts to be installed v be installed dry on the clean towel	m a visual ins vith Isopropyl	pection of th Alcohol and	e parts to be let the parts t	to	
17.2	Prepare screws and washer to be used for and washer visual inspection; clean screw bath and let screws and washers dry on a	ws and washer	llation. Perfo s in an Isopro	orm a screws opyl Alcohol		
17.3	Perform a visual inspection of the CORIVNUTS. If necessary clean them with	OVER check Isopropyl Alc	the cleanlin	ess of all th	ne	
17.4	Weight all the hardware to be installed	, including fa	steners. Reco	ord the weigl	ht	
	TTTL		· · · · · · · · · · · · · · · · · · ·			
	ITEM Bold	WEIGHT				
	(NAS 352NO6LB-8) X TEA	7,4	4 6		Jat	Jason
						}
						Andrew and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second and the second
17.5	SCALE PN AJ-4>007 M#	Cal	Date08   14	800<	JeH	Japon
	st Short (ATS) Cooling the D. AGE (ATS)					

	AMC DO TACK CHEET (ATO)		5. Page 79 ATS 09	ot 0127-	116 1Rn
	AMS-02 TASK SHEET (ATS)  CONTINUATION PAGE	4. ATS NO.			
20. OPER	21, OPERATIONS	6. MOD NO.		VERIF	CATION
17.6	(Print, Type, or Write Legibly)			22. TECH	23. QA/D
	WARNING: TTCB installation reference drawi of this ATS.  Verify before use the availability of the approve	ed drawing revision	at the start		
17.6.1	Check the bill of material in the assembly drawi	ng.	weekeeste to the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the same and the s		
17.6.2	apply a thin lay between washers and base plate and or compone Ltt-700/910-704  Koropron primer - PN Lot#	ver of Koropron printentExp. Date		- CH	Japon
17.6.3	Install the indicated components as shown in the				

20. OPER SEQ. NO.	S-02 TASK SHEET CONTINUATION PAGE		4. ATS NO. 6. MOD NO.	AI	VER 22. TECH	RIFICATION
	CONTINUATION PAG	21. OPERATIONS	6. MOD NO.			
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		(Print, Type, or Write Legibly)			22. TECH	4 23. QA/D
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	AMS-02 TASK S CONTINUATION			4. ATS NO.	AI	S 090127-	1-R0
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I C C	Dash Number Screw NAS1352N06-6 Check this value with the	Torque  Max  13.861  table at the en between 1–1	(in*lbf) Min 11.782 d of this ATS. 0 inch*lbf (siz	ze 0.138).			
I C C	Dash Number  Screw  NAS1352N06-6  Check this value with the cocking torque shall be in the check this value with Talk in the check this value with the school torque shall be the school torque shall be the school torque shall be the school torque shall be the school torque shall be the school torque shall be the school torque shall be the school torque shall be the school to the school torque shall be the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the school to the	Torque  Max  13.861  table at the en between 1–1	(in*lbf) Min 11.782 d of this ATS. 0 inch*lbf (siz	ze 0.138).			
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				5. Page 83	of	116
	AMS-02 TASK SHEET (ATS)		4. ATS NO.		S 09012	
	CONTINUATION PAGE		8. MOD NO,		· · · · · · · · · · · · · · · · · · ·	
20. OPER SEQ. NO.		ERATIONS or Write Legibly)		_1,,		RIFICATION
18.	INSTALLATION OF Cover Rib to Bas	se plate rivnu	ts 2		22. TEC	H 23. QA/DI
18.1	Prepare the Rib for installation. Perform installed; clean the parts to be installed to be installed dry on the clean towel	a visual inspe with Isopropyl	ection of the pa Alcohol and le	rts to be et the parts t	0	
18.2	Prepare screws and washer to be used fo and washer visual inspection; clean scre- bath and let screws and washers dry on a					
18.3	Perform a visual inspection of the base p If necessary clean them with Isopropyl A	plate check the	cleanliness of	all the hole	s.	
18.4	Weight all the hardware to be installed	l, including fa	steners, Recor	d the weigh	nt	**************************************
	ITEM	WEIGHT				
	Bolt		······································			
	NAS 13 52 NOGLB-12 (2001)	3.,	8 9		JUM	Jason
	SCALE		<del></del>			
18.5	PN AJ-4200Z M#	Cal	Date_08 [14 ]	>008	JCH	Japan
	Sheet (ATS) Continuation Rev 9/25/06 JH					

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	AMS-02 TASK SHEET (ATS)	4. ATS NO.	5. Page 84 ATS (	or 090127-	116 -1-R0
·····	CONTINUATION PAGE	6. MOD NO.			
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)				FICATION
18.6	WARNING: TTCB installation reference drawing of this ATS.  Verify before use the availability of the approved		at the start	22. TECH	23. QA/O
18.6.1	Check the bill of material in the assembly drawing	ng.			
18.6.2	apply a thin layouter between washers and base plate and or component \$15-700/910-704  Koropron primer - PN Lot# 370655	nt. ,		JcH	Jacon
18.6.3	Install the indicated components as shown in the				
	(Screw) NAS1352N86-12				
	Sigure 4: Connection of cover rib to base plate		7	,	

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	AMS-02 TASK SHI	, ,		4. ATS NO.	ATS	090127	-1-R0
	CONTINUATION	PAGE		6. MOD NO.			
20. OPER SEQ, NO.		21. OPERA (Print, Type, or V	TiONS Vrite Legibly)				IFICATION
18.6.4	Apply a thin layer of prior the installation (as	reported on the	assembly di	to the threads	of each bolt	22. TEC	23. QA/DV
	Braycote Grease - PN		-	~ /	208	JCH	Jason
18.7	Install the fasteners as per hand)			s lot number (v	write by		
	Bolt/washer/nut and numb	er NAS nur	nber	LOT			
		<del></del>	LO	Γ#			
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	Bolt	NASISTZNOLI	18-17 TOT	# Zttor	<del></del>	JCH	Jason
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		*,·······	LOT	#			
18.8	Torque the fasteners installe torque values are shown in	ed in the former below table.	step to the f	inal torque val	ue. Seating		
	Dash Number	Torque	(in*lbf)				
	Dash Number	Max	Min				
	Screw NAS1352N06-12	13.861	11.782		1		
18.9	Check this value with the tab	ole at the end of	this ATS.			!	
I	ocking torque shall be in bo	etween 1–10 inc	ch*lbf (size	0.138).			
18.10 C	Check this value with Table inal torque shall be the seat precision on torque.	1 at the start of t	his ATS.	·		. The second is the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second statement of the second sta	***************************************

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Torque Wrench-I  PN XORC OOO  Bolt indication (s  Rib_to_bat  Rib_to_bat	Final Torque  M#  ee figure above) Locking To  e	Cal Due Date 09/0	ue) /2009 Torque	JCH JCH JCH	Jason

					5. Page 87	of	116
	-	AMS-02 TASK SHEET (A CONTINUATION PAGE	TS)	4. ATS NO.		090127-	1-R0
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20. OPER SEQ. NO.			21. OPERATIONS Print, Type, or Write Legibly)				FICATION
		Auxiliary to	0			22. TECH	23. QA/DV
9. INS	TALLA	TION OF <b>TEMPORARY I</b>	NSTALLATION	N TOOL TO COV	ER		
19.1	Prepa the pa	re the Cover and auxiliary too arts to be installed; clean the e parts to be installed dry on	ol for installation.	Perform a visual in	omaatia		
19.2	CHILLE VY	re screws and washer to be u asher visual inspection; clear and let screws and washers dr	n screws and was	here in an Iconsons	a screws Alcohol		
19.3	Perfor RIVN	m a visual inspection of t UTS. If necessary clean then	the COVER che	ck the cleanliness	of all the	DX.	
19.4		t all the hardware to be ins			the weight		
		ITEM	WEIGHT				
							*
	50						
	SCALE						
19.5			Ca				
		For Secon decided not to bracket => No	dary bo	e auxilia	7		

	AMO OO TAOY OUT		5. Page 88		116
	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	4. ATS NO.	ATS	090127-1	I-R0
20. OPER		6. MOD NO.		And the second	
SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)				CATION
19.6	WARNING: TTCB installation reference drawings of this ATS.  Verify before use the availability of the approved drawings.			22. TECH	23. QA/DV
19.6.1	Check the bill of material in the assembly drawing.				
19.6.2	between washers and base plate and or component.	of Koropron prin	mer in		
	Koropron primer - PN Lot# I	Exp. Date			
19.6.3	Install the indicated components as shown in the fig	ure below.			
	REFORE COVER INSTALLATION	(21			
	(20.1)	7			
			p .		
		59			
	Isometric view: INSTALLATION SETUP - WITHOUT COVER - WITH AUXILIARY TOOL				
	(Screw) NAS1352N3	-8			
	(Nut) NAS1291C06N	M			
		X 2			
	Figure 4: Connection of auxiliary tool to cover  Installation tool no	of insta	lled		

	AMS-02 TASK S	SHEET (ATS	)	4. ATS NO.	5. Page 89 ATS	or 090127-	116 I-R0
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20. OPER SEQ. NO.		2 (Print,	1. OPERATIONS Type, or Write Legibly)			VERIF	ICATION
19.6.	Apply a thin layer of prior the installation	f Charles Sign	MAAGAMASIKA	, to the threads drawings).	of each bolt	22. TECH	23. Q.
	Braycote Grease - PN	L	ot#E	xp. Date			
19.7	Install the fasteners as hand)	per figure 4 ar	nd record fastene	ers lot number (w	rite by		
	Bolt/washer/nut and nu	mber NA	S number	LOT			
0		1	LC	)T#			
	T 1 11 +		LC	)T#			
-	Installati	on too	LO LO	T#			
-	not insta	Med	LO	T#			
-		-	LO	T#			
-		9	LO	T#			
-		-	LO	T#			
-			LO	T#			
-		-	LO	Γ#			
9.8	Torque the fasteners inst Seating torque values are	shown in bel	rmer step to the ow table.	following torque	value.		
	Dash Number	Max	Min				
	Screw NAS1352N06-6	13.861	11.782				
A	Check this value with the As this is a temporary scr The Locking torque shall	ew and a nut v	without locking	feature.			
1			ABOVE LOCK		1		

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	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	4. ATS NO.	Als	090127-1	-RU
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O. OPER EQ. NO.	21. OPERATIONS (Print, Type, or Write Legib		CATION		
				22. TECH	23. QA/I
	Torque Wrench- Locking Torque (locking is the PN	Cal Due Date  Cal Due Date  Final T			
11 E	nd of online operation auxiliary tool to cover				

				0.1	····	4 4 6
ļ 1	AMS-02 TASK SHEET (A	NTS)	4. ATS NO.	5. Page 91 ATS	S 090127	116 '-1-R0
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20. OPER SEQ. NO.		21. OPERATIONS (Print, Type, or Write Legibly)	<u> </u>	<u> </u>	VEF	RIFICATION
20.	INSTALLATION OF Cover to				22. TECI	1 23. QA/D\
20.1	Prepare the Cover for installation installed; clean the parts to be installed dry on the clean tower	a. Perform a visual installed with Isoprops	nspection of the polyderial Alcohol and le	parts to be t the parts to		
20.2	Prepare screws and washer to be and washer visual inspection; clear bath and let screws and washers d	an screws and wach	tallation. Performers in an Isoprop	n a screws yl Alcohol		
20.3	Perform a visual inspection of inserts to be used. If necessary cle	the base plate chec can them with Isopro	k the cleanlines	ss of all the	*	
20.4	Weight all the hardware to be in			I the weight		
	ITEM	WEIGHT				
	Bolt		· · · · · · · · · · · · · · · · · · ·			
	NASISTINOS-8 X8	H.	049		JOH	Jason
	Washer				7	
	NAS1149EN83ZR X8	3,5	g 9			
	SCALE					
20.5	PN AJ-4>00E M#	Cal	Date08/14/20	800	Jay	Japon
20.6	WARNING: TTCB installation re of this ATS.  Verify before use the availability of	eference drawings ar	e as indicated at			
Assembly Task	Sheet (ATS) Continuation Rev 9/25/06 JH				1	

	AMS-02 TASK SHEET (ATS)	4. ATS NO.	5. Page 92 AT	S 090127	116 1-R0
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20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly,			VER	FICATIO
20.6.1	Check the bill of material in the assembly drav		•	22, TECH	23.
20.6.2	apply a thin labetween washers and base plate and or compor	nent.  Exp. Date	imer in 4/09	JeH	Ire
20.6.3	Install the indicated components as shown in the	e figure below.			
	(Screw) NAS1352N08-B				
	(Washer) NASI149EN832R				

	AMS-02 TASK SI CONTINUATIO			4. ATS NO.		93 ATS	090127	116 '-1-R0	
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20. OPER SEQ. NO.		21, OPERA (Print, Type, or V	TIONS Vrite Legibly)			***************************************		RIFICATION	_
20.6.4	prior the installation (	as reported on the	assembly d	rawings).			22. TEC	H 23. QA/D	V
	Braycote Grease - PN_	Lot# =	28999 Ex	sp. Date 06	boro	and a supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party of the supremper party	Jan	Japon	V
20.7	Install the fasteners as pe hand)	er figure 4 and reco	ord fastener						
	Bolt/washer/nut and num	nber NAS nun	nber	LOT					
1		- Addition of Symphologopean	LO	Γ#		To a for any and a format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of the format of t			ĺ
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0.8	Forque the fasteners instal orque values are shown in	led in the former s below table.	tep to the f	inal torque val	ue. Seat	ing			
	Dash Number	Torque (	in*lbf)						
	Screw	Max	Min			İ			
	NAS1352N08-8	24.944	21.203						
1.9 C	heck this value with the ta	able at the end of t	his ATS.						
L	ocking torque shall be in t	oetween 1.5-15 inc	ch*lbf (size	0.164)					
.10 C Fi	heck this value with Table nal torque shall be the sea % precision on torque.	2 1 at the start of the	nic ATS					and the second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second s	

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	CBP_1 CBP_3  CBP_5 CBP_7	CBP_4		
P	orque Wrench-Final Torque	Due Date	309 Ja	1 Jason
P	N XQAA0357 M# Cal D	Due Date 05/20/201	) ] JCH	Japon
В	olt indication (see figure above) Locking Torque	Final Tor	'que	
	<u>CBP_1</u> 8	3/.5	JUH	Jason Jason
	CBP_2 9.5	33	JCH	7
	CBP_3 8.5			

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20.11	Bolt indication (see figure above)  CBP_5  CBP_6  CBP-7  CBP-8  End of online operation cover to base	8 8 7.5 9 10 9	32 32 32	32	Jay Jay Jay Jay Jay Jay	Jason Jason Jason Jason

# Pg6- Pioo See Also Addendum TII.

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20. OPER		1. OPERATIONS	6. MOD NO.		1	
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1. 21.1	INSTALLATION OF BASE PLATI Prepare the BASE PLATE for install	ation Perform	visual inapaction	of the		
21.2	parts to be installed; clean the parts to the parts to be installed dry on the clean the parts to be installed dry on the clean second washer visual inspection; clean second washer visual inspection; clean second washers dry of the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed; clean the parts to be installed dry on the clean the parts to be installed dry on the clean the parts to be used and washer visual inspection; clean second washer visual inspection; clean second washer visual inspection; clean second washer visual inspection; clean second washer visual inspection; clean second washer visual inspection; clean second washer visual inspection; clean second washer visual inspection; clean second washer visual inspection; clean second washer visual inspection; clean second washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visual washer visu	ean towel  I for the part ins	tallation, Perform a			
21.3	Perform a visual inspection of the US the inserts to be used. If necessary cle	SS SIMILIF A TO	D shoots the death	ness of all		2
21.4	Weight all the hardware to be instal	led, including f	fasteners. Record th	he weight		
	ITEM	WEIGHT				
	30/6	WEIGHT				
		WEIGHT	165.06 3		Jey	Japon
	\$0 ts NAS 35 N4-16 X M Waster NAS 587-4 4 M	WEIGHT	165.06 g 27.34 g		Jey	Japan
	Bolts NAS 35 N4-16 × M Washer		7		Jey	Japan
	Bolts  NASIZEINUL-16 X M  Washer  NASI587-4 4 M  Thermal Washer		×1.34 g		Jey	Tues
S	BOILS  NASIBENUL-16 X M  Waster  NASIBEN-4 M  Thermal Waster  15.7 X 42		>7.34 g 86.52 g		Jey	Japan
21.5	#01ts  NAS 35 N4-16 x 1  Washer  NAS 587-4 + 1  Thermal Washer  15.7 x 42		×1.34 g		Jey Jey	Jacon

AMS-02 TASK SHEET (ATS) CONTINUATION PAGE  21. OPERATIONS BEEC NO.  21. OPERATIONS PORK Types, or with Lephby  22. TOPERATIONS BEEC NO.  21. OPERATIONS PORK Types, or with Lephby  22. TOPERATIONS PORK Types, or with Lephby  22. TECH 22. OF The Properation of this ATS.  Verify before use the availability of the approved drawing revision  21. 6. Check the bill of material in the assembly drawing.  21. 6. Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Screw/NAS1351NA-16  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  Install the indicated components as shown in the figure below.  Install the indicated components as shown in the figure below.  Install the indicated components as shown in the figure below.  Install the indicated components as shown in the figure belo		AMS_02 TASK	PUEET (A	TO	1	5. Page 97	000127	116 1 PO
21.60 WARNING: TTCB installation reference drawings are as indicated at the start of this ATS.  Verify before use the availability of the approved drawing revision  21.6.1 Check the bill of material in the assembly drawing.  21.6.2 apply a thin layer of Koropron primer in between washers and base plate and or component.  Koropron primer - PN Lott Exp. Date  21.6.3 Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7   Tax 67 x 4   Thermal Washer-15.7   Tax 67 x 4   Thermal Washer-15.7   Tax 67 x 4   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7   Thermal Washer-15.7				18)	4. ATS NO.	Als	090127-	1-KU
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apply a thin layer of Koropron primer in between washers and base plate and or component.  Koropron primer - PN Lot# Pold Exp. Date  Lot# Lot# Lot# Lot# Lot# Lot# Lot# Lot#		Verify before use the	availabilit	y of the approve	d drawing revisio			
between washers and base plate and or component.  Koropron primer - PN  Lot# Total  Exp. Date  Lot# Total  Exp. Date  Lot# Total  Exp. Date  Lot# Total  Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7    (Wusher) NAS1587-4	21.0.	Check the off of ma	ieriai in the	assembly drawn	ng.			25
21.6.3 Install the indicated components as shown in the figure below.  Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7    (Washer) NAS1587-4	21.6.2	between washers and	base plate	and or compone	nt.		T.,,	_
Base Plate Installation (ET5998-06-3)  Thermal Washer-15.7  [(Washer) NAS1587-4]  (Screw) NAS1351N4-16  Dash Number  Max  Min  NAS1351N4-16  102.375  87.019  Thermal Washer-15.7  Id x 6.7 x 4  X 18  (Washer) NAS1351N4-16  [(Washer) NAS1351N4-16		Koropron primer - Pi	N	_ Lot# 10631	Exp. Date	7/01	JCH	-kos
Thermal Washer-15.7	21.6.3	Install the indicated of	omponents	as shown in the	figure below.			
Thermal Washer-15.7   14 x 6.7 x 4		Base Plate Ins	stallation	(ET5998-06	-3)	Thermal Was	sher-15.7	7
14 x 6.7 x 4				Thermal Washer-15	.7	14 x 6.7 x 4		١
(Screw)NAS1351N4-16   (Washer)NAS1351N4-24   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16   (Screw)NAS1351N4-16	ł	(Washen) NAS1587-4		14×6.7×4	X2			X 18
Corew)NAS1351N4-24   102.375   87.019   NAS1351N4-24   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375   102.375		(Screw)NAS1351N4-16		A.	7			
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Dash Number Torque (in*lbf)  Max Min  NAS1351N4-16 102.375 87.019  NAS1351N4-24 102.375 87.019  NAS1351N4-24 102.375 87.019				- The state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the		(Screw	)NAS1351N	1-24
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Dash Number Torque (in*lbf)  Max Min  NAS1351N4-16 102.375 87.019  NAS1351N4-24 102.375 87.019  NAS1351N4-24 102.375 87.019			1	· C 688	199999			
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Dash Number         Torque (in*lbf)           Max         Min           NAS1351N4-16         102.375         87.019           NAS1351N4-24         102.375         87.019    (Screw) NAS1351N4-16				11 (15.6)	900	Thermal Washe	er-15.7	
Max Min  NAS1351N4-16 102.375 87.019  NAS1351N4-24 102.375 87.019  NAS1351N4-24 102.375 NAS1351N4-16				(1) (1) (1) (1) (1) (1) (1) (1) (1) (1)	S.C.	1		X 22
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Yangania a		14751331N4-10	341.323		8	(Screw) NA	S1351N4-16	
87.019		NASI35INA 24	1117 116	87,019				X 11
· ·			S 200 2 1	97.010				
			S 200 2 1	87.019				
			S 200 2 1	87.019				
		NAS1351N4-20	102.375					
Figure 4: Connection base plate to USS simulator		NAS1351N4-20	102.375					

	AMS-02 TASK	SHEET (ATS)			5. Page 98	090127-	116 1 PO
	CONTINUAT		-	4. ATS NO.	1113	030127-	1-10
. OPER				6. MOD NO.			- 8
Q. NO.		(Print, Type	PERATIONS e, or Write Legibly)			VERIF 22. TECH	23. QAV
1.7	prior the installation  Braycote Grease - PN	Lot#  T- Lot#  T- Lot#  T- Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The Lot#  The	the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly described by the assembly descr	s lot number (w	vrite by	<b>Ј</b> сн	Juso
	Washer Thermal Washer	NAS Lts		made by Tikani	103	JUE.	Jacon 7
-			LOT	#			
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3 T to	Forque the fasteners instorque values are shown  Dash Number	in below table.	er step to the fi	nal torque valu	e. Seating		
		Max	Min				
	NAS1351N4-16	102.375	87.019				
	NAS1351N4-24	102.375	87.019				-
L	NAS1351N4-20	102.375	87.019				
Lo	neck this value with the cking torque shall be in			0.250).			

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	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	4. ATS NO.	AIS	090127-	1-R0
		6. MOD NO.			
OPER Q. NO.	21. OPERATIONS (Print, Type, or Write Legibl	у)		VERIF 22. TECH	ICATION 23. QA
1.10	Check this value with Table 1 at the start of this Final torque shall be the seating torque ABOVE 5% precision on torque.	ATS. LOCKING TORQU	E.		
	Base Plate Installation (ET5998-06	-3)	Thermal Washer-	2.7	
	Thomal Washer-IS   Green   TAS   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Washer   18   Wash		Washers	CAS1507-4 CL351014-24	S
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	Dash Number Torque (in 'lui)		p		-
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	NAS1351N4-24 102.375 87.019 NAS1351N4-20 102.375 87.019			[XI	
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1	BD_USS_2_8 23	/13		CH J	aspa
	BP_USS_ 2_7 25	118		CH -	-0.(
	/			VIII	

## pg6-p100 See also Addendun III.

	AMS-02 TASK SHEET (ATS	5)	4. ATS NO.	ATS	of 090127-	116 1-R0
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20. OPER SEQ. NO.	(Print	21. OPERATIONS , Type, or Write Legibly)				FICATION
	Bolt indication (see figure above)	Locking Torque	Final T	orque	22. TECH	23. Q/
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- E1	nd of online operation base plate to U	SS		-		

#### P101-P105 See Addendum IV.

			6.	Page 101	of	116
	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE		4. ATS NO.	ATS	090127	'-1-R0
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20. OPER SEQ. NO.	21. {Print, Ty	OPERATIONS  /pe, or Write Legibly)				RIFICATION
					22. TEC	H 23. C
2. 22.1	INSTALLATION OF SIDE PLATE  Prepare the SIDE PLATE for installat to be installed; clean the parts to be installed dry on the clean to	ion. Perform a vi	igual imamanti — C	the parts let the		
22.2	Prepare screws and washer to be used and washer visual inspection; clean scr bath and let screws and washers dry or	for the part insta	llation. Perform a s s in an Isopropyl A	screws		
22.3	Perform a visual inspection of the USS the inserts to be used. If necessary clear	S SIMILI ATOR	check the cleanline	ess of all		
22.4	Weight all the hardware to be installed			waight		- Service (5)
1		, , , , , , , , , , , , , , , , , , , ,	record the	weight		
1		T ====				
	ITEM	WEIGHT				1
	Bolt	1				
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	Washer Thermal Washer			$\exists$		
	15.6 × 11	1'	7.16 9			
	15.7 × 11	V	2.66 8			
	Nut			7 1		
	NA51789C4M	£4	.62 9			
5	SCALE					
22.5	PN AJ-4200Z 32010757 M#	Cal D	Date_ 08/14/200	8	SCH :	Jacon
22.6	WARNING: TTCB installation referent of this ATS.	ce drawings are	as indicated at the	start		

### P 101 - p105 See addendum IV

	AMS 02 TASK OUTST (ATS)			of 116 0127-1-R0
	AMS-02 TASK SHEET (ATS)  CONTINUATION PAGE	4. ATS NO.	A15 09	0127-1-R0
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22.6.1	Check the hill of motorial in the		2:	2. TECH 23. QA/D\
22.6.2	Check the bill of material in the assembly dra			
22.0.4	between washers and base plate and or composition of the second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second s	layer of Koropron prin onent. LG 64 Exp. Date	1	H Jacon
22.62				,
22.6.3	Install the indicated components as shown in	the figure below.	1	
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		11.	-3-1/V	
		//	and ser	
		00000	3880	
	(Nut)NAS1789C4M	(880 E	8 D	- Table
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	14 x 6.7 x 3	S Silver		
	Thermal Washer -15.7	1		0000
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	(Screw)NAS1351N4-20	3(3)(3)	V	
			Co.	
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	Figure 4: Connection side plate to USS simulat	or	1	
2.6.4	Apply a thin layer of	to the threads of e	ach holt	
1	prior the installation (as reported on the assemb	ly drawings).	7.	7
Br	raycote Grease - PN Lot#/35999	Exp. Date 0602	80	Jacon
	6012Fxto/2-AMSB	_ Exp. Date		
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98.1			1	1 1

## p101-p105 See Addendum IV.

	AMS-02 TASK	SHEET (ATS)		4. ATS NO.	5. Page 103 ATS	090127	116 -1-R0
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20. OPER SEQ. NO.		21. O	PERATIONS			VER	IFICATION
22.7 22.8	Install the fasteners as hand)  Bolt/washer/nut and not Bolt  Thormal Washer  Thormal Washer  Nut	per figure 4 and umber NAS  ASISTIA  15.	number  LOT	LOT 8/88  F#		JCH	Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction of the Contraction o
	T		LOT	4			
2.8	Torque the fasteners ins torque values are shown	in below lable.	er step to the fi	4	. Seating		
2.8	Torque the fasteners ins torque values are shown  Dash Number	Torque	er step to the fi	4	. Seating		
2.8	torque varies are shown	in below lable.	er step to the fi	4	. Seating		

## P101- p105 See addendum TV.

20, OPER	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	4. ATS NO.	ATS 090127-1-R0
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20, OPER		6. MOD NO.	
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	5% precision on torque.		22. TECH 23.
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	(Nut)NAS1789C4M	SP USS 1 SP US	- CO
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	Thermal Washer -15.6	10 9999	3006
		Mark Comment	10000
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11			
	(Screw)NAS1351N4-20	537	
	X 11		
Т	orque Wrench- Locking Torque (locking is the	same as running torque	
Pl	111111111111111111111111111111111111111		A CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR OF THE CONTRACTOR
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		, , , , , , , , , , , , , , , , , , ,		2	2. TECH	23. QA/I
	Bolt indication (see figure above)	Locking Torque	Final	Torque		
	SP USS 1 SP USS 1 SP USS 4 SP USS 3 SP USS 1	20 15 18 19 21 21	109   109   111   112	7	TCH TCH H	Japon Japon Japon Japon Japon Japon
of onli	ne operation side plate to USS					

For Flight Radiator Installation see Addendum I.

	AMS-02 TASK SHEET (ATS)		4. ATS NO.	AT	S 09012	/-1-R0
	CONTINUATION PAGE		6. MOD NO.			
20. OPER SEQ. NO.		PERATIONS			VE	RIFICATION
SEQ. NO.	(Print, Type	e, or Write Legibly)			22. TEC	23, QA/0
3. 23.1	INSTALLATION OF DUMMY STAR' SIMULATOR Prepare the DUMMY START-UP RAI			Perform		
	a visual inspection of the parts to be ins Isopropyl Alcohol and let the parts to be	talled; clean the	parts to be insta	alled with		
23.2	Prepare screws and washer to be used for and washer visual inspection; clean scre bath and let screws and washers dry on	ews and washers	llation. Perform s in an Isopropyl	a screws l Alcohol		
23.3	Perform a visual inspection of the BAS check the cleanliness of all the inserts Isopropyl Alcohol	SE PLATE ANI to be used. If	O SIDE PLATE necessary clean	INSERT them wit	Sh	
appended to	CONTRACTOR OF THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE REAL PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PROPERTY AND THE PRO					1
23.4	Weight all the hardware to be installed	d, including fas	teners. Record	the weigh	nt	
23.4	ITEM	d, including fas	teners. Record	the weigh		
23.4			teners. Record	the weigh	JCH	Ireon
23.4	ITEM	WEIGHT	teners. Record	the weigh		Iron
23.4	ITEM Bolt	WEIGHT	12 9	the weigh		Isson
23.4	ITEM Bolt NASIZEIN3-16 XI6 Washer NASII49ED363R XI6	WEIGHT	12 9	the weigh		Iraom
23.4	ITEM Bolt NAS1341N3-16 X16 Washer	WEIGHT		the weigh		Irron
23.4	ITEM Bolt NASIZEIN3-16 XI6 Washer NASII49ED363R XI6	WEIGHT 69.	12 9	the weigh		Ireon
23.4	ITEM Bolt NASIBEINS-16 XI6 Washer NASII49ED363R XI6 Thermal Wosher	WEIGHT 69.	12 9	the weigh		Iron
23.4	ITEM Bolt NASIBEINS-16 XI6 Washer NASII49ED363R XI6 Thermal Wosher	WEIGHT 69.	12 9	the weigh		Iron
	ITEM Bolt NASIBEINS-16 XI6 Washer NASII49ED363R XI6 Thermal Wosher	WEIGHT 69.	12 9	the weigh		Isson

Flight radiotor in Addendum I

			5. Page 107	of	116
	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	4. ATS NO.	ATS	090127-	1-R0
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20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)			VERIF	FICATION
23.6				22. TECH	23. QA/DV
23.6.1	WARNING: TTCB installation reference drawing of this ATS. Verify before use the availability of Check the bill of material in the assembly drawing the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the contr	f the approved dra	d at the start wing revision		
23.6.2	between washers and base plate and or component of the plate and plate and or component of the plate and or component of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of the plate of t	er of Koropron pr nt. Exp. Date	imer in	Jc4	Ison
23.6.3	Install the indicated components as shown in the				
	(Screw)NAS1351N3-16  (Washer)NAS1149E0363R  X 16  Thermal Washer -15.5 12.8x5x4  N 32	5.5) 221	6 6 6	00	
23.6.4 B	Figure 4: Connection radiator plate to base plate TAKE NOTICE THE DUMMY RADIAT THIS PICTURE. USE HOWEVER THE S NUMBERING  Apply a thin layer of prior the installation (as reported on the assembly of Lot# 131999 E	OR IS NOT SEAME BOLT  , to the threads ordrawings).	Feach bolt	Joy -	Ireon
_	Sheet (ATS) Continuation Rev 9/25/06 JH	xp. Date			

Flight radiator in Addendum I.

				5. Page 108	of .	116
	AMS-02 TASK SI CONTINUATIO		4. AYS NO.	AIS	090127-	1-R0
	CONTINOATIO	NPAGE	6. MOD NO.			
20. OPER SEQ. NO.		21. OPERATIONS (Print, Type, or Write Legibl	ly)		VERIF 22. TECH	23. QAVDV
			-	77 2 3 3 3 3		
23.7	Install the fasteners as p hand)					
	Bolt/washer/nut and nur	nber NAS number	LOT			
	Bolt			3		7
	Washor	1/01/11/9702/3D	LOT# 4621	7	JCH	Jason
	Thermal washer	H Y		(,		
	threath torsteb	7.3	LOT#			
			LOT#			
			LOT#			
			LOT#			
			LOT#			
			LOT#			
			LOT#			
			-			
23.8	Torque the fasteners insta		) a			
	torque values are shown	in below table.				
	Dook Novel	T	orque (in*lbf)			
	Dash Numbe	Max	Min			
	Screw	42.23	7 35.901			ē
	NAS1351N3-					
23.9	Check this value with the	table at the end of this	ATS.			
	Locking torque shall be in	hetween 2.0-18 inch*l	hf (size 0.190)		Sec. 1	
23.10	Check this value with Tab					
	Final torque shall be the s					
			*			

# Flight radiator in Addendum V.

	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS 090127-1-R0
	CONTINUATION PAGE	6. MOD NO.	
OPER D. NO.	21. OPERATIONS (Print, Type, or Write Legibly)		VERIFICATIO
	5% precision on torque.		22. TECH 23.
		<b>(4)</b>	
		The state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the s	IC DE TEXTE DE LESSON DE
15 16			
		RP	_1RP_8
	(Sciew)NAS1351N3-16	96	an too
			662
	(Washer)NAS1149E0263R	A Comment	00
	NIE I		
	X16	000	
	Thermal Washer -15.5		0.00
	12.8x5x4 X 32	RP 9	RP 16
		We do not have been a second	
	Torque Wrench- Locking Torque (locking is the sa	ame as running torque	e)
-	XQu/(0117)		f/2009 JCH Jac
		an Due Date	
	Torque Wrench- Final Torque	08/1	+ 1209 JCH June
	PN XAWCOIIV M#_ C	al Due Date	t/2009 JCH Just
			*
	Bolt indication (see figure above) Locking Torq		
-	RP_   >1 (wa)	48.	JCH Ives
	BP-2 16	40.	_ July Jae
	BP_9 Ovar(28)	18	70.1
			JUT Japas
-	RD 10 NO (SO)	+X	
-	BP_10	<u> </u>	JUY Jam

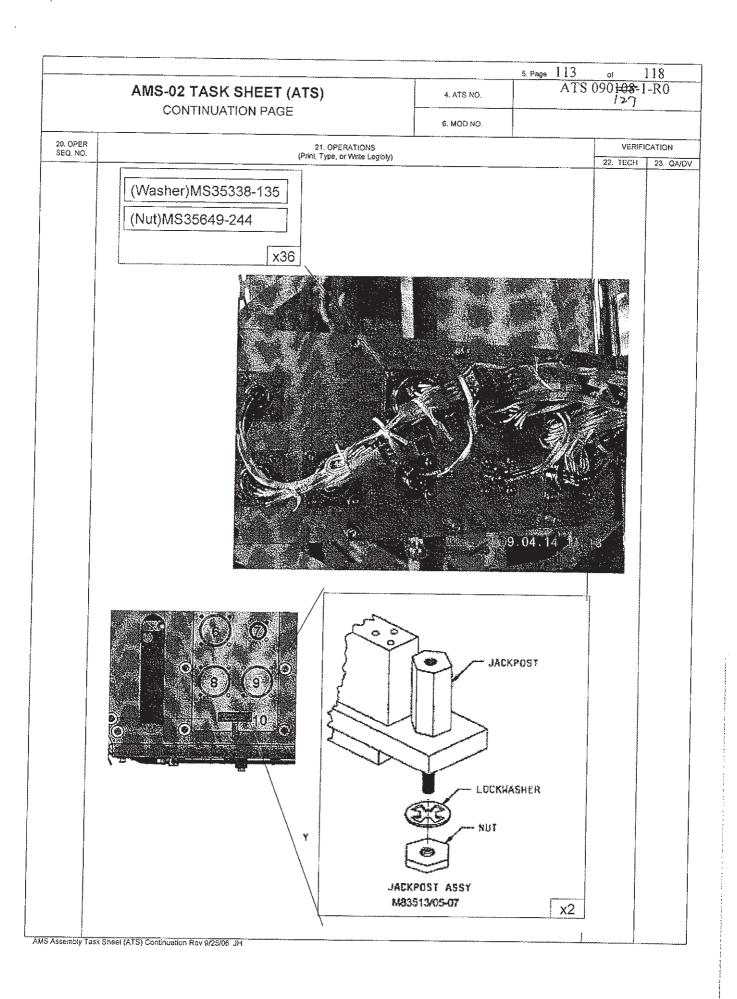
## Flight radiator in Addendum I

	AMS-02 TASK SHEET (AT	S)	4. ATS	5. Pa	ATS	of 090127-	116 1-R0
	CONTINUATION PAGE	65	6. MOD	NO.			
OPER Q. NO.	(Prin	21. OPERATIONS at, Type, or Write Legibly)	<u> </u>		-	-	CATION
						22. TECH	23. QA
	Bolt indication (see figure above)	Locking To	rque	Final To	que	JEH	Ireo
	<u> </u>	OVER 100	(xf)	32	_	JCH	Jaso
					_		
	· ·						
					_		
-			_		-		
I	End of online operation dummy radia	tor plate insta	llation		-	, .	
					-	1	

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		5. Pag	
	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	4. ATS NO.	ATS 090 <del>108</del> -1-R0
	CONTINUATION PAGE	8. MOD NO.	
20. OPER SEQ. NO.	21. OPERAT (Print, Type, or W		VERIFICATION  22. TECH   23. QA/DI
24.	INSTALLATION OF CONNECTOR TO	O COVER PANEL	
24.1	Prepare the Cover for installation. Perform installed; clean the parts to be installed with be installed dry on the clean towel	a visual inspection of the parts the Isopropyl Alcohol and let the	to be parts to
24.2	Prepare screws and washer to be used for the and washer visual inspection; clean screws bath and let screws and washers dry on a cl	and washers in an Isopropyl Ale	cohol
24.3	Perform a visual inspection of the COV RIVNUTS. If necessary clean them with Iso	ER check the cleanliness of opropyl Alcohol	all the
24.4	Weight all the hardware to be installed, in	ncluding fasteners. Record the	weight
	ITEM	VEIGHT	
	Bolt	121011	
	NASI352CO4-6 (3629)	71.6 g	JCH Japon
;	Washer		
	MS35338-135 (36ZA)	2.52 g	
	Nut		
Anna	MS35649-244 (362A)	18,0 9	
	SCALE		
24.5	PN AJ-42007 M#	Cal Date 08/14/2008	_ JCH Jacon
	- 10		

A			5. Page 112 of	118
	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	4. ATS NO.	ATS 090 <del>108</del> - /ン7	-1-R0
	CONTINUATION PAGE	6. MOD NO,		
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)		VERI 22. TECH	FICATION 23. QA/DV
24.6	WARNING: TTCB installation reference drawing of this ATS.  Verify before use the availability of the approved			23. (4/15)
24.6.1	Check the bill of material in the assembly drawing	g.		
24.6.2	between washers and base plate and or component よらつの / 910 つり としま   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100   100	of Koropron prim	ler in  109  TCH	Jam
24.6.3	Install the indicated components as shown in the fi	gure below.		
	(screw)NAS1352C04-6 x36			
		26 3 0	3 3 1 3 3	
The state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the s	Sheet (ATS) Continuation Ray 9/25/06 JH			



AMS-02 TASK SHEET (ATS) CONTINUATION PAGE  21.0PERATIONS (PMILTIPE OF WINGE Lighty)  24.6.4 Apply a thin layer of prior the installation (as reported on the assembly drawings).  Braycote Grease - PN	ERIFICATION  23. QA/DV
Figure 4: Connection of connector to cover panel  24.6.4 Apply a thin layer of prior the installation (as reported on the assembly drawings).  Braycote Grease - PN	ZH 23. QA/DV
Figure 4: Connection of connector to cover panel  24.6. Apply a thin layer of prior the installation (as reported on the assembly drawings).  Braycote Grease - PN Lot# 3599 Exp. Date 660 > 08  24.7 Install the fasteners as per figure 4 and record fasteners lot number (write by hand)  Bolt/washer/nut and number NAS number LOT  Washer Ms 35338-135 LOT# "/  Nut Ms 35449 - X44 LOT# LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT#  LOT	ZH 23. QA/DV
Apply a thin layer of prior the installation (as reported on the assembly drawings).  Braycote Grease - PN Lot#   35999   Exp. Date   660 \( \) OP    Col27 - Yok-AMSB    24.7 Install the fasteners as per figure 4 and record fasteners lot number (write by hand)   Bolt/washer/nut and number   NAS number   LOT    Washer   MS   352 col4 - 6   LOT# No information    Washer   MS   3538 -   35   LOT#    Nut   MS   3549 - Yet   LOT#    LOT# LOT#    LOT# LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#    LOT#	
Install the fasteners as per figure 4 and record fasteners lot number (write by hand)  Bolt/washer/nut and number NAS number LOT  ASSISTACO4-6 LOT# No Information  John Massistation  J	1
Bot NAS 3\$zco4-6 LOT# No information  Washer Ms 3\$338- 3\$ LOT# "  Nut Ms 3\$b49 - X44 LOT# "  LOT# LOT# LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT#  LOT# LOT# LOT#  LOT# LOT# LOT#  LOT# LOT# LOT#  LOT# LOT# LOT# LOT#  LOT# LOT# LOT# LOT# LOT# LOT# LOT# LOT#	
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24.8 Torque the fasteners installed in the former step to the final torque value. Seating torque values are shown in below table.  Dash Number Torque (in*lbf)  Screw Max Min	
Torque the fasteners installed in the former step to the final torque value. Seating torque values are shown in below table.  Dash Number Torque (in*lbf)  Screw Max Min	
Torque the fasteners installed in the former step to the final torque value. Seating torque values are shown in below table.  Dash Number Torque (in*lbf)  Screw Max Min	
Torque the fasteners installed in the former step to the final torque value. Seating torque values are shown in below table.  Dash Number Torque (in*lbf)  Screw Max Min	
Screw Max Min	
NAS1353C04 C	
NAS1352C04-6 7.459 6.34	
M83513/05-07	
24.9 Check this value with the table at the end of this ATS.	
Locking torque shall be in between 0.5-5 inch*lbf (size 0.112).	
Check this value with Table 1 at the start of this ATS. Final torque shall be the seating torque ABOVE LOCKING TORQUE. 5% precision on torque.	

	4.4			5. Page 115	of	118
	AMS-02 TASK SHEET CONTINUATION PAG		4, ATS NO.	ATS	0901 <del>08</del>	-1-R0
	CONTINUATION PAG		6. MÓD NO.			
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	Torque Wrench- Locking Torqu	e (locking is the sa	me as running torque			Plant of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state
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]	Bolt indication (see figure abov			orque		
	CNI_I	loss than		-	JUH	Jason
-	CNIZ	less than	1 8		701	
	CN1_3	/	-		J UM	Jaeon Jaeon Jaeon Jaeon
		less than			JCH	Jacon
	CNI_4	loss than	8		JUH	Jason
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20. OPER SEQ. NO.		21, OPERATIONS (Print, Type, or Write Legibly)		VERII 22. TECH	FICATION 23. QAV
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	3	less than 1	8	JUT	Jaso
	_4	(ess than 1	8	JU	Jaco
	CN3_	less than 1	8	JU	Japo
	_ 7	less than 1	8	JCH	Jaso
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	_ 4	less than 1	8	JCH	Japa
	CN4_1	less than 1	8	JCH	Japo
	_ 2	less than 1	8	JUH	Jaso
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	_ ~~~~	less than 1	8	JCH	Jazo
	3	less than 1	8	JCH	Jaso
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	CN6 1	less than 1	8	JCH	Jaso
	7	less than 1	8	JCH	Jaco
	3	less than 1	8	JCH	Jason
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Arrana 11/00 taglereness	CN7_1	less than 1	8	JCH	Jazor
	_ Z	less than 1	8	JCH	Japon
	3	less than 1	8	JCH	Jason
	isk Sheet (ATS) Continuation Rev 9/25/06 JH	loss than 1	8	JCH	Jaco

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20. OPER SEQ. NO.		21. OPERATIONS (Print, Type, or Write Legibly)			-	ICATION
		(First, Type, or Write Legicity)			22. TECH	23. QA/0
	CN8_1	less than 1	[3 <del>-1</del>	8	JCH	Jaco
	_ 2	less than	-	8	JCH	Jason
	_ 3	less than		8	Jay	Jason
	_ 4	less than	_	8	JCH	Jason
	CN9_1	less than		8	JUT	Jacos
	_ ~~	loss than	1	8	JUH	Jaco
	3	less than	1	8	JUY	Jaso
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			5. Page 116		16
	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS	090127-1	-R0
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				VERIFI	CATION
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legii	bly)		22. TECH	23. Q/V/DV
	25. Appendix 1: Seating Torque Value	es (2009_01_09)			

		d Mintorg	ue summary of T	ICS Parts	Issue 20090109			acfinication
	Bolt			Insert/Nut Wash		· · · · · · · · · · · · · · · · · · ·	Torque	(in*lbf)
		Number	Dash Number	Number	Dash Number	Number	Max	Min
Joints D_Brackets_FICB_Shar	Dash Number			9	NAS1587-4	9.	102.375	87.019
ed	NAS1351N4-24	9	MS21209 F4-15	12	NAS1587.4	12	-:102.375 as	87:010
Base plate &USS	NAS1351N4-16		MS21200F4-15 NAS1789C4M	以海川路 Silina 11	no	11	102,375	87.019
Side plate &USS	NAS1351N4-20	41	144317690418					
Start up radiator &base/sideplate	NAS1351N3-18	16	MS21209F1-25	16	NAS1149E0363R	16	42,237	36,901
	NAS1352N08-8	/10	MS21209C0820	10	NAS1149EN832R	10	24,944	21.203
cover &base	NAS1352N06-6	2.	NAS1330-06-108.	2	, no	0	13,861	11.782
Accumulator bracket &base plate	NAS1351N3.16	8	MS21209F1-15	8	NAS1149E0363R	В	42.737	35.90
nimp Bracket & start up radiator	NAS1352N06-10	. 8	NAS1291C06M	8	NAS1149EN532R	<b>8</b>	13.861	11.78
Ans Dps & Base plate	NAS1352NOB 14	8 8 18	MS21209C0020	9	NAS1149EN032R	A.	24.944	21.20
HXE Base plate.	NAS1351N3-18	T 4 6	MS21209 F1-15	8	NAS 620 10 LC	8	42.237	36.00
old orbit heater &base plate	NAS1352N08-10	4	N1S21209C0820	4	NAS1149EN832R	4	24.944	21.20
Controller &base plate	NAS1351N3-10	6	MS 124695 10 32X1.5@a	6	na	0	42,237	35.90
Cover&Coverfuls	NAS1352N06-6	25	NAS1330-00-106	25	NAS1149EN532R	25	13.861	11.70
Cover Rib&Baseplate	NAS1352N06-12	2	NAS1330-06-106	2	110	0	13,861	11.78
Protioater&Baseplate	NAS1352N04-LB-6	0	no	: B	a do a	. 0	7,459	6.34
onnectorsPlate&Cover	NAS1952N06-6	10	NAS1338-06-106	10	NAS1149EN532R	10	13.861	11.78
PressSensors&Cover	NAS1352N06-8	9	MS21209C0620	. 8	100	. 0	13.861	11.78
PipeClamp&BasePlate	NAS1352N08-8	1.5	MS21209C0820	4	no	0	24.944	21.20
PipeClamp&PipeClamp	NAS1352N06-0	8	MS21289C9610	В	no	0	13,861	11.78
ClampBracker&Collar				o	NAS1149EN832R	7.	26.863	22.83
Parisan was a favor and a same far-	NAS1351N06-10	9	MS21209F0G25	8	NAS1149EN532R	8	15.662	13.31
Pipe-Fix&Claimp	NAS1351N08-10	8	MS21209F0020	0.00	NAS1149EN032R	1 Apr 8 14.	26.863	22.83
Press&Saddle Pipe claimp and cover	NAS1352N06-12	2	NAS1330-06-106	2	no.	0.50	13.861	- 11.78



## Addendum I to ATS ogo127-1-Rd

					5. Page 27		16
	AMS-02 TASK SH			4. ATS NO.	ATS (	090127-1-	-R0
	CONTINUATION	B-S		6. MOD NO.			
20. OPER	D. OPER 21. OPERATIONS						
6.7 6.8	Install the fasteners as perhand) Bolt/washer/nut and num  NAS 1352 N  braycole great  601 EF Arts 13  Low 135999  POM: 060208.  Super Koro  Low 500014  Exp. date 11  Torque the fasteners instatorque values are shown	r figure 4 and ber NAS  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB-  106 LB	be, or Write Legibly)  If record fasten  S number  -/2 L  L  L  L  L  L  L  L  L  L  L  L  L	DT#OT#OT#OT#OT#OT#OT#OT#OT#OT#OT#OT#OT#OT#OT#OT#OT#OT#OT#	10/2009.	ichileang	23. Q/VDV
	Dash Number	Max	(in*lbf) Min				
	Screw NAS1352N06-12	13.861	11.782				
6.9	Check this value with the	1,56 e table at the	1,33 end of this AT				
	Locking torque shall be i						
6.10	Check this value with Ta Final torque shall be the 5% precision on torque.				Е.		
	File to Lot #: 0	RIVNO 5-10-	uT: NI	15 1330 NO 018.	06-106	10/11/6g JuE.	

Addender I to ATS 090127-1-Rd Replacement NAS 1352 NO6-12 with NAS 1352 NO6-LB12

			5. Page 28		16
	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS	090127-1	-R0
	CONTINUATION PAGE	-			
	TTCB-S	6. MOD NO.			
20. OPER	21. OPERATIONS			VERIFIC	
6.11	PC_COV_1  PC_COV_1  PC_COV_2  Torque Wrench- Locking Torque (locking is the sare took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of the same took of th	al Due Date	rque)	J. V.E.	

LOCATION: SERTS, TERN, ITANY ENGINEER: ELUA LAUDI DATE: 617 MAY 2009, GERRIT V DONC

GERRET V DOLL

Addendum I Lo ATS 090127-1-RO

	A	MS-02 TASK SHEET (ATS) CONTINUATION PAGE		4. ATS NO.	ATS (	090127-1	
		CONTINUATION FACE	*******	6. MOD NO.		Vissie	
20. OPER SEQ. NO.		21. OPERA (Print, Type, or W				22. TECH	23. QA/DV
13. INST		TION OF <b>PUMPS</b> ONTO THE TTO re the TTCS PUMP for installation.		IY RADIATOR			
13.1	to be i	nstalled; clean the parts to be installed of be installed dry on the clean towel	ed with Isc			q.D.	
13.2	and wa	re screws and washer to be used for the asher visual inspection; clean screws and let screws and washers dry on a contract of the screws and washers dry on a contract of the screws and washers dry on a contract of the screws and washers dry on a contract of the screws and washers dry on a contract of the screws and washers dry on a contract of the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screws and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer to be used for the screw and washer t	s and wash lean towel	ers in an Isopro	pyl Alcohol	E.L.	
13.3	Perfor inserts	m a visual inspection of the base . If necessary clean them with Isopro	plate; che opyl Alcol	ck the cleanling	ess of all the	4.D.	
13.4	Weigh	at all the hardware to be installed,	including	fasteners. Reco	rd the weight	Ē,L.	
		ITEM	WEIGHT	× -			
	9	SCREW NAS 1352 NOG-10	11.3	8			
		WUT DAS 1291COGH	2.9	8	1		
		WASHER JAS 1149EN532R	4.5	}		*	
	SCAL				,		
13.5	PN	KB 10000-1 M#	(	Cal Date	/	E.L.	4
AMS Assembly	Task Sheet (A	NTS) Continuation Rev 9/25/06 JH					

## Addendum II to ATS ogo127-1-16

					5. Page 58		16	
	AMS-02 TASK SHI	as record and the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the same of the		4. ATS NO.	ATS	090127-1	-R0	
	CONTINUATION	PAGE		6. MOD NO.				
OPER			PERATIONS			VERIFIC	CATION	
Q. NO.	A 1 4h i 1 6 C	100000000	e, or Write Legibly)	to the threads a	foodb halt	22. TECH	23. Q	
13.6.4	prior the installation (as	s reported on	the assembly	drawings).	192	EL		
3.7	Install the fasteners as per figure 4 and record fasteners lot number (write by hand)  Bolt/washer/nut and number NAS number LOT							
		8						
	WASHER N							
	NUT N	-						
	LOT#							
	LOT#							
	LOT#							
	LOT#							
3.8	Torque the fasteners instatorque values are shown i			ne final torque val	ue. Seating	ε.ι.		
	D 1 37 1 1	Torque	(in*lbf)					
u	Dash Number	Max	Min					
	Screw NAS1352N06-10	13.861	11.782	1.566-1.31	(uh he			
5.9	Check this value with the	table at the en	nd of this AT	S.		×		
	Locking torque shall be in	n between 1–	10 inch*lbf (	size 0.138).				
3.10	Check this value with Tab Final torque shall be the s	ole 1 at the sta	art of this ATS	S.	F (	DK.		

### Addendum II to ATS 090127-1-Rf.

				5. Page 60	of 1	16
	AMS-02 TASK SHEET (ATS	3)	4. ATS NO.	ATS	090127-1	-R0
	CONTINUATION PAGE		6. MOD NO.			
00 0050		21. OPERATIONS			VERIFIC	CATION
20. OPER SEQ. NO.	(Print	, Type, or Write Legibly)			22. TECH	23. QA/DV
	Bolt indication (see figure above)	Locking Toro	que F	inal Torque		
13.11	End of online operation pumps					
						9
9						
-						
AMS Assembly	Task Sheet (ATS) Continuation Rev 9/25/06 JH					

LO CATION: SERMS

AMS Assembly Task Sheet (ATS) Continuation Rev 9/25/06 JH

LO CATION: SERMS Adde noturn ITT ENGINEER (S): ELISA LAND DATE: 5 MAY 109 LO ATS OGO127-1-RO GERRY 1. DONIC

					5. Page	96		116
	A	MS-02 TASK SHEET (ATS)		4. ATS NO.	TTCB		090127-1 CNDAR	
		CONTINUATION PAGE		6. MOD NO.		Ge -	CIPAIC	
20. OPER			ERATIONS	1000			VERIF	ICATION
SEQ. NO.		(Print, Type, c	or Write Legibly)				22. TECH	23. QA/DV
21.	Prepar	TO FINAL TO ALLATION OF BASE PLATE TO the BASE PLATE for installation of the installed; clean the parts to be the to be installed dry on the clean	on. Perform a	visual inspecti th Isopropyl Al	ion of th	e nd let	Щ	
21.2	Prepar and wa	re screws and washer to be used for asher visual inspection; clean screwnd let screws and washers dry on a	or the part inst	tallation. Perfor	rm a scr	ews		
21.3		m a visual inspection of the USS serts to be used. If necessary clean	them with Ise	R check the cle	eanliness ol			
21.4	Weigh	at all the hardware to be installed	d, including f		ord the	weight		
		ITEM	WEIGHT			-		
						-		
						+		
						1		
	SCAL	E				_	172	-
21.5	PN	<b>M</b> #	C	al Date			N.A	
21.5	PN_	M#	Ca	al Date		_	A.A	

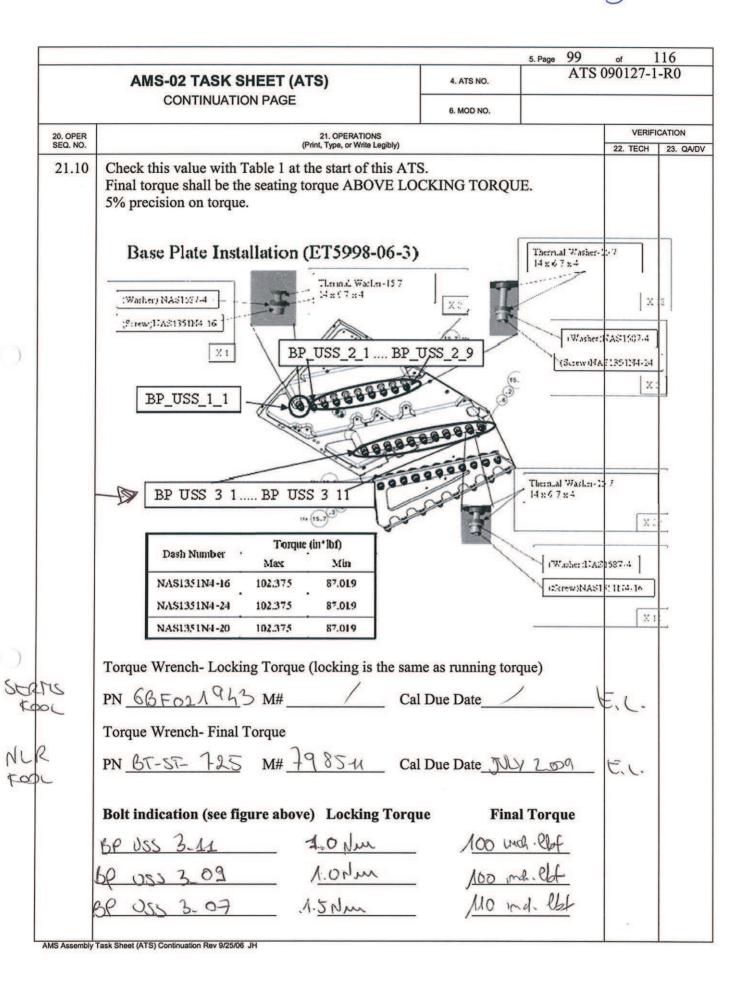
				¥	5. Page 97		116
	AMS-02 TASK SH		)	4. ATS NO.	ATS	090127-1	-R0
	CONTINUATION	PAGE		6. MOD NO.			
20. OPER			1. OPERATIONS	•		VERIFI	CATION
SEQ. NO.	WILLIAM TO THE TOTAL	100/07/10	Type, or Write Legibly)		■ Strate w ■ oc. 1 complex constr	22. TECH	23. QA/D
21.6.1	WARNING: TTCB insof this ATS. Verify before use the a	vailability	of the approved	drawing revision			
21.6.2	between washers and between washers and between washers and between known of the Koropron primer - PN  Install the indicated co	pase plate an	nd or componer	Exp. Date	mer in	E.L.	
	Base Plate Inst			A CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF CONTRACTOR OF	Thermal W: 14 x 6.7 x 4	asher-15.7	
	(Washer) NAS1587-4	3	Thermal Washer-15 14 x 6.7 x 4	17 X2		asher)NAS13511 w)NAS13511 sher-15.7	X4-24 X 9
							X 22
	Dash Number	Torque Max	(in*lbf) Min		(Washe	)NAS1537-4	
	NAS1351N4-16	102.375	87.019			NAS1351N4	16
	NAS1351N4-24	102.375	87.019		(batow)		
	NAS1351N4-20	102.375	87.019				X 11
	Figure 4: Connection l	base plate to	o USS simulato	r			

Addendum III to ATS ogo127-1-RO

					5. Page 98		16	
	AMS-02 TASK SH	The state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the s	4.7	ATS NO.	AIS	090127-1	-R0	
	CONTINUATION	PAGE	6. M	MOD NO.				
20. OPER SEQ. NO.		21. OPERA (Print, Type, or V				1.2870	CATION	
21.6.4	Apply a thin layer of		6010H (C1), to th	e threads o	f each holt	22. TECH	23. QA/D	
21.0.	prior the installation (a ALRE AC Braycote Grease - PN	as reported on the	assembly drawin	gs).		51		
21.7	Install the fasteners as perhand)  AUDINA  Bolt/washer/nut and num		GHT BOLTS AT	number (w	rite by	とし		
i.	Bolt washer/hat and han							
		2	LOT#					
	LOT#							
	LOT#							
-	LOT#							
-	in the second second							
21.8	Torque the fasteners instatorque values are shown	in below table.		torque val	ue. Seating	E.C.		
	Dash Number	Torque	(in*lbf)	ł				
		Max	Min					
-	NAS1351N4-16	102.375	87.019	(11,57	-9,83 Nm			
	NAS1351N4-24	102.375	87.019					
	NAS1351N4-20	102.375	87.019	]				
21.9	Check this value with the	table at the end	of this ATS.					
21.7								

(0.4-3.39 Nm)

Addendum III to ATS og 0127 - 1-Ko



Addendum III to AUS egoizy -1-KA

	AMS-02 TASK SHEET (ATS)			ATS	090127-1	-R0
	CONTINUATION F	PAGE	6. MOD NO.			
20. OPER SEQ. NO.		21. OPERATIONS (Print, Type, or Write Legibly)			VERIFICATION 22. TECH	CATION 23. QA/D\
	Bolt indication (see figure	e above) Locking Torque	Fina	l Torque		
	BB US\$ 505	m6 F.0	100 in	of lbt		
	BP USS2 03	25 Jm	M5 1m	: lst		
	BP 0553 01	2,0 pm	MS in	. elsf		
	BP USS3_ 10	2.0 dr -	105 m	. llot		
	6P 0353-8	1-0 Nem	100 m.	la		
	BP USS3-6	1.5 Nm	105 m	elst.		
	68 0332 h	1.0 dm,	100,0	. let		
	Be 0223- 2	-uhos	MS IN	.est		
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	S <del></del>	_				
21.11	End of online operation bas	se plate to USS				

DATE: 5/147 109 to ATS OGOIZY-1-Rd ENGINEER: ELUA LAUDI
DATE: 5/147 109

					5. Page 101		16
	Al	MS-02 TASK SHEET (ATS)		4. ATS NO.	ATS O	090127-1	
		CONTINUATION PAGE		6. MOD NO.			
20. OPER		21. OPERA (Print, Type, or V				VERIFIC	CATION
SEQ. NO.	0-0	PLANE TO FINAL TORK				22. TECH	23. QA/DV
				VIII 1 MOD			
22.	INSTA	ALLATION OF SIDE PLATE TO	USS SIM	ULATOR			
22.1	to be in	e the SIDE PLATE for installation.  Installed; clean the parts to be installed be installed dry on the clean towel	ed with Iso		and let the	ET	
22.2	and wa	e screws and washer to be used for asher visual inspection; clean screws and let screws and washers dry on a co	s and wash	ers in an Isoprop	yl Alcohol	F.L	
22.3		m a visual inspection of the USS SI erts to be used. If necessary clean th				E.C	
22.4	Weigh	t all the hardware to be installed,		fasteners. Recor	d the weight	E.C.	
		ITEM	WEIGHT	Ű.			
		и					
	SCAL						
22.5	PN_	M#	C	Cal Date		4.4	
22.6	of th Veri	RNING: TTCB installation reference is ATS.  fy before use the availability of the PS) Continuation Rev 9/25/06 JH					

### Addendum TV to ATS o go127-1-Kd

			5. Page 102 of	116
	AMS-02 TASK SHEET (ATS)	4. ATS NO.	ATS 090127-	1-R0
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22.6.1	between washers and base plate and or componer	er of Koropron prin	mer in	-3
	Koropron primer - PN Lot#	Exp. Date		
22.6.3	Install the indicated components as shown in the	figure below.		
	(Nut)NAS1789C4M Thermal Washer -15.6	98888	3 8 8 9 W	7 18x
	14 x 6.7 x 3  Thermal Washer -15.7 14 x 6.7 x 4  (Screw)NAS1351N4-20	320	600000	900
	X 11			
22.6.4	Figure 4: Connection side plate to USS simulators  Apply a thin layer of prior the installation (as reported on the assembly	, to the threads o	of each bolt	0
	NO GREASE APPLIED	Exp. Date		

Addendem IV to ATS og 0127-1-Kt.

				5.	Page 103		16	
	AMS-02 TASK SH	1 To 1 To 1 To 1 To 1 To 1 To 1 To 1 To	4	ATS NO.	ATS (	90127-1	-R0	
	CONTINUATIO	NPAGE	6.	. MOD NO.				
20. OPER		21. OPER					CATION	
SEQ. NO.	Install the fasteners as p	(Print, Type, or		t number (wri	to by	22. TECH	23. QA/DV	
22.1	hand)	BEREON	TO IN A	MINDE (WII	le by	E.L.		
	USE INSTALLATION	BOLTS NOT FL	IGHT BOLLS A	AND C				
	Bolt/washer/nut and nun	nber NAS nu	imber	LOT				
		). <del></del>	LOT#_					
		<u> </u>	LOT#_					
			LOT#_					
		LOT#						
	LOT#							
			LOT#_					
22.8	Torque the fasteners inst torque values are shown		er step to the fina	al torque value	e. Seating	E.L		
	Torque (in*lbf)							
	Dash Number	Max	Min	(11 =	0 = 7 1 1			
	NAS1351N4-20	102.375	87.019	(M,51-	9,83hm			
22.9	Check this value with th	e table at the end	of this ATS.	_				
				0.050		- 1		
	Locking torque shall be	in between 3.5-30		1.M)		E.L.		
22.10	Check this value with Ta Final torque shall be the							
	The contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contraction of the contracti			action of the supplied of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the contro				
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			5. Page 104 of 116
	AMS-02 TASK SHEET (ATS) CONTINUATION PAGE	4. ATS NO.	ATS 090127-1-R0
	CONTINUATION PAGE	6. MOD NO.	
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)		VERIFICATION
	(Nut)NAS1789C4M  Thermal Washer -15.6 14 x 6 7 z 3  Thermal Washer -15.7 14 x 6 7 x 4  (Screw)NAS1351N4-20  X 11  Torque Wrench- Locking Torque (locking is the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the state of the s	SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP USS 1 SP	22. TECH 23. QAD  15.7 24  18. C.  Torque
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	SPS 155 3 0.5 Nm	100 in.	Ust.
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AMS-02 TASK SHEET (ATS)			5. Page 105 of 116 ATS 090127-1-R0			
CONTINUATION PAGE			6. MOD NO.			
0. OPER SEQ. NO.		21. OPERATIONS (Print, Type, or Write Legibly)		VERIFICATION  22. TECH   23. QA/E		
	Rolt indication (see fig	ire above) Locking Tor	aue Final	Torque		
	SPS USD 4	1.2 N.M	105 mg.			
	SPS USS 10	0.4522	100 in 8			
	SPS USS 8	0.3 N.m	100 200-1			
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of on	line operation side plate to	USS				
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LOCATION: SERMS, TERNÍ. ITALY DATE: 687 MAY 2009

ENGINEER: ELUA LAUDI GERRAT V DONK

Addendum I to ATS 090127-1-Rd

		ATS 090127-1	
20. OPER SEQ. NO.	21. OPERATIONS (Print, Type, or Write Legibly)	VERIFI 22. TECH	CATION 23. QA/D
23.1	INSTALLATION OF DUMMY START-UP RADIATOR TO USS SIMULATOR  Prepare the DUMMY START-UP RADIATOR PLATE for installation. Perform a visual inspection of the parts to be installed; clean the parts to be installed we Isopropyl Alcohol and let the parts to be installed dry on the clean towel	orm	
23.2	Prepare screws and washer to be used for the part installation. Perform a screw and washer visual inspection; clean screws and washers in an Isopropyl Alcol bath and let screws and washers dry on a clean towel		2.00.2
23.3	Perform a visual inspection of the BASE PLATE AND SIDE PLATE INSECUENCE the cleanliness of all the inserts to be used. If necessary clean them Isopropyl Alcohol		
23.4	Weight all the hardware to be installed, including fasteners. Record the w	eight E.C.	
	ITEM WEIGHT		-
	RADIATOR PLATE (HEATERS) 961,7 9 NAS 1351 N3-16 X 16EA 68,79		
	NAS 1169 = 0363 RXAGER 15, 2 g		
		-	
	SCALE	]	
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23.7	Install the fasteners as per figure 4 and record fasteners lot number (write by hand)						
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	SCREW NAS 1351	N3-16 LC	T# 46213				
	WASHER MASMAR	E0363R LC	T# UN857				
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23.8	Torque the fasteners installed in the	former step to the	final torque valu	e. Seating			
23.0		Torque the fasteners installed in the former step to the final torque value. Seating torque values are shown in below table.					
	Dash Number	Torq	ue (in*lbf)	1_1			
	Dasii i tuinoti	Max	Min	2			
	Screw	2020-2020-20	24/24/24/24				
	Screw NAS1351N3-16	42.237	35.901	1,00			
	NAS1351N3-16	(4.77 -	4.058 N.	m)			
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23.9	NAS1351N3-16  Check this value with the table at the	( ム・テラ - e end of this ATS	4.058 N.	m)			
	NAS1351N3-16  Check this value with the table at the Locking torque shall be in between 2	( 4.77 - e end of this ATS  2.0-18 inch*lbf (196 - 2.03	4. 058 N. size 0.190).				
23.9	NAS1351N3-16  Check this value with the table at the	e end of this ATS  2.0-18 inch*lbf (1)  2.6 - 2.03  start of this ATS	4. 058 N. size 0.190).	OK			
	NAS1351N3-16  Check this value with the table at the Locking torque shall be in between 2.  Check this value with Table 1 at the	e end of this ATS  2.0-18 inch*lbf (1)  2.6 - 2.03  start of this ATS	4. 058 N. size 0.190).	OK			

# Addendur V to ATS 090127-1-Kp

AMO OO TAGIK QUEET (ATQ)				5. Page 110 of 116 ATS 090127-1-R0		
AMS-02 TASK SHEET (ATS) CONTINUATION PAGE		4. ATS NO.			-7/98	
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	RP-6		65 m/s.	Acres 100		
	20-7		60 ind.			
	RP -8		60 ind.	ebt.		
	RP- 9	1.5 Nm	55 md	Prolot-		
	RP_10	1.5 mm	S5 1md	1. lbf-		
	RP_U	2.0 Nm	55 Incl	lst.		
	RP- 12	3.0 Nm	65 mah	. llst		
	RP-13.	9.5 Mm	60 inch	· lbf.		
	Rp_1h	2.5 du	60 inl	est.		
	F6-12	3.5 Nur	65 ma	E 100		
	RP-16	25 Nm	60 jm	. lbf		
		<u> </u>				
		on dummy radiator plate insta				
	TO REMOVE TO	B FROM TRANSPORT		1 BOLTS	15	
	RP 15	RE-TORQUED:	55 1	nd. Obf.	07/05 E.L.	
	, 4 = 200		1	,	C.C.	
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